



Faculty of Engineering

Department of Textile Engineering

REPORT ON

‘Comparative study on woven and knit garment quality report’

Course Title: Project (Thesis)

Course Code: TE 4214

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This Report Presented in Partial Fulfillment of the Requirements for the Degree of Bachelor of Science in Textile Engineering.

Advance in Apparel Manufacturing Technology



Faculty of Engineering

Department of Textile Engineering

Approval Sheet

This research entitled “**Comparative study on woven and knit garment quality report**” at Daffodil International University, April 2018” prepared and submitted by **Md. Mahbubur Rahman Adnan (ID: 143-23-3387) & Md. Shofiul Azam (ID: 142-23-3895)** in partial fulfillment of the requirement for the degree of BACHELOR OF SCIENCE IN TEXTILE ENGINEERING has been examined and hereby recommended for approval and acceptance.

A handwritten signature in black ink, appearing to read 'Md. Abdullah Al Mamun'.

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Declaration

We attest that this report is totally our own work, except where we have given fully documented references to the work of others and that the materials contained in this report have not previously been submitted for assessment in any formal course of study. If we do anything, which is going to breach the first declaration, the examiner/supervisor has the right to cancel my report at any point of time.

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Dedication

Dedicated to the whole RMG workers , who gives total morning to night, contribute running the wheel of country economy by their quality work. Thank you so much, go forward, we are always with you

Acknowledgements

Research is a difficult task. Different types of assistance and guidance are required to perform this task properly. This project entitled as “ **comparative study on woven and knit garments quality report**” been completed by my raw hands. Actually this report is a series of inspiration, guidance and co-operation that I received from various persons during the period of the task. Hence I invent myself in the ties of gratitude in every step of the study. Gratitude is such a feeling that can’t be expressed through writing only.

First of all I want to express my heartiest gratitude to almighty God. I am grateful to my project supervisor **Abdullah Al Mamun** Assistant Professor Department of textile engineering , University of Dhaka for giving me proper guidance and suggestions throughout the research process. I’m grateful to him for being patience despite all of my mistakes.

I extend my cordial thanks to my all course teachers department of textile engineering , Daffodil International University for her valuable suggestions and important lecture in class at all stages of this research. I would like to thank library staffs of central library of Daffodil International University for their support and co-operation at the time of literature review. Without which it was impossible to conduct the research. Special thanks goes to **A H M Shamiul Basir Raza, IE manager ,Fair Trade group** ; and Also Thanks to **Mr. Md. Rafiqul Islam, Director, AmanTex Ltd.** who arrange the Permission letter for doing the project work in that Industry & variable advice to carry out the project work.

Finally, I would like to thank especially the respondents who afford their valuable time and giving information about their personal and family matter earnestly and with patience.

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Abstract

Fair Trade Group and Aman Tex Ltd Garments Personalized Limited forayed throughout the textile trade. Initially recognized to deal with the accelerated demands of your export advertise, today, people are a energetic presence with the hosiery road of Bangladesh. The learning was done in System in Fair Trade group And Aman Tex Ltd garments by using of huge amount regular sewing machines, ironing makers,. Both information and appliance cutting is implemented in it unit. The agency is producing plenty garments each and every day. Defect a occurrence is about the main perils faced by just them but it may transpire by the two machine as well as operator mistake. In this case, identifying this frequently going on defects while in the garment is vital in an effort to minimize most of the occurrence. The learning has also been conducted had to have 45 time. In it study 20 instructions were analyzed meticulously. Defective pieces and therefore the types involving defects can be been uncovered in all of these 20 jobs. Analyses are intended with the details and faults percentage is certainly identified. Factors that cause the defects are normally found out and even analysed within the study. This study is really an effort to eliminate the defects with the production operation. If a service can reduce the faults in formation process, then company formation rate will increase with increased profitability. The deficiency percentage is beyond the okay norms of your company designed for defects perimeter, in obtain to correct or underestimate it, this mission study is accomplished. The initial help this research is usually a systematic study from the production department to spot the flaws. The generated data had been classified along with tabulated. Simple tables had been prepared together with liberally familiar with exhibit the particular classified data to make easy along with better perception of the analyze. The generally occurring defects and therefore the defects which have been contributing more with the total ratio of disorders are recognized by categorization investigation and chi-square researching. The nearly all occurring defects while in the garments tend to be found to become skipped stitch, lube spot and even loop slanted for example.. The major factors that cause occurrence of defects can be improper tension with the disk, repetitive entry to machines, improper handling for the garment in addition to needle carelessness. It is certainly suggested the fact that the company can target these disorders mainly as well as technically a number of suggestions are shown to decrease the issues. This most likely way designed for increasing the condition of productivity and also save any time.

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Chapter -01

Introduction

1.1 Background of the study:

Textile plays a crucial role throughout the market of Bangladesh. By simply that it is the lifestyle for the Bangladeshi financial state. But this approach place fails to get the following place instantly. The textile industry regarding Bengal is amazingly old. From the increasing demand to the eastern civilization from the production in advanced silk cotton yarn, long-lasting couture fibers search and additionally cultivation are written.

The biggest manufacturing routines of linen and attire sector Bangladesh. It provides direct occupations to 5 , 000, 000 people, which operates for 50 percent skin color art works near your vicinity. Textile and also clothing establishments (T & C) supplies a single method to obtain economic growth within the rapidly acquiring economy connected with Bangladesh. Export regarding textiles plus garments is definitely the main method to obtain foreign alternate earnings. This sector is just not grown within 24 hours.

Garment High quality Control requires examining a merchandise, service, or process in the minimum quality of an minimum clothes quality. A high-quality control collection aims to identify new product lines that usually do not meet the suitable quality from a company's superior quality.

If a difficulty is determined, it might be temporarily to give up production of your quality restrain team or maybe professional. Depending relating to specific products, as perfectly as the kind of problem, production or even implementation regarding identified issues most likely is not completely not open. Garment quality should ensure level of quality control so the processes can be enough to satisfy your goals and objectives. Simply place, quality assurance makes sure that a product is accurately produced, carried through, manufactured as well as produced, while evaluating the high quality control that the effect is great.

In the actual garment market quality regulate is practiced right from the 1st stage in sourcing unprocessed trash concise of remaining finished item of clothing. For textile and clothes industry supplement quality is without a doubt calculated when considering quality in addition to standard connected with fibers, yarns, textiles construction, tone fastness, surface designs additionally, the final done garment products and solutions. However level of quality expectations for the purpose of export are in connection with as well as the customer segments and also the retail sites.

1.2 Objectives of this thesis:

- To be aware of the superior quality control.
- To identify the particular reason why of dresses fails.
- To be aware of the take care of quality in the garments.
- To have a very good statistics breakdown of sample disappointed

1.3 Scope of this thesis:

- Study, measure and help individual efficiency
- Establish a more suitable system in order to rectify the particular sample disaster

1.4 Research Design:

Research design part is called the blue print of the research. It actually shows the way of how the research is done. The research design varies with qualitative, quantitative and mixed methodology.

However, it is the planning of the research. Research design includes the time management, planning etc. An overall research of my research design is given below:

Title: time frame of the study

| Activities | Date |
|---|---|
| Selection of topic | 1 st to 10 th February |
| Literature review | 10 th to 17 th February |
| Finalizing objectives and research hypothesis | 17 th to 20 th February |
| Development of questionnaires/ checklist | 20 th to 20 th March |
| Data collection coding and analysis | 20 th 05 th April |

Chapter -02

Literature Review

2.1 Quality:

Each and every product features some special characteristics for which it is in demand by consumers. History of quality is as old as human civilization itself. Aristotle 2500 years ago defines quality as following:

1. Quality is the difference between products.
2. It is the goodness or badness in products.

This definition holds true till this date. However, in general terms quality encompasses important characteristics of a product for which it is in demand. Quality is also referred to as “conformance of goods to buyer’s specification”. ISO 9000:2000 defines quality as “Degree to which a set of inherent characteristics fulfill requirement.

2.1.1 Quality objectives:

- Seeking customer’s needs and expectations, and meeting their requirements to the fullest.
- Knowing and achieving the applicable regulatory requirements.
- Simultaneously improving market shares.
- Improving productivity and reducing costs.
- Providing necessary assets including knowledge not to mention training to workers.
- Involving people at all levels.
- Maintaining high standard of safety, health and environment.

2.1.2 Quality Types:

1. Product control:

The control which is used to decrease defective items within different lots of produced good is known as product control. It is applied after production process.

2. Process control:

Controlling of process sequence or steps to produce desired quality product is called process control. There are two types of process control which is given below

a. Online quality control:

This type from quality control is performed in process position i. e. without stopping the production process, during typically the production running time frame, the machine automatically tests the model and takes prompt step to correct the variation. This type from quality control is performed in process position i. e. without stopping the production process, during typically the production running time frame, the machine automatically tests the model and takes prompt step to correct the variation.

b. Offline quality control:

This particular quality control consists of laboratory tests which are usually done by ceasing the production course of action. Here necessary steps are taken according to test result.

Example: Garments final test from lot

Shade matching during dyeing

2.1.3 Buyer Quality Types:

In terms of quality level buyers, clothing is classified in 3 categories likes,

The first quality – A grade

Second quality - B grade

Third quality - C grade

First Quality:

The buyer who are able to satisfy the buyers and maintain all its qualitative features and that may be not in every major accident is considered first quality or perhaps a grade. A-grade dress looks good. They do not possess any leading accidents during purchase and therefore are not denied towards wear quality.

Second quality:

The buyer who are able to satisfy the buyers and maintain all its qualitative features and that may be not in every major accident is considered first quality or perhaps a grade. A-grade dress looks good. They do not possess any leading accidents during purchase and therefore are not denied towards wear quality.

Third quality:

Although this particular dress has numerous tiny wounds, maintaining functional quality and as a salesperson, such as the sale capability. They sometimes lose some general good-looking features but do not lose acceptance because of buyers. Some of typically the flaws visible from outside may also be these dresses. Some buyers allow two major flaws through second quality attire. 3 or further major flaws turn down them

2.1.4 Importance of quality:

1. Certain aspects of the functionalities of each product and her shape, size, and design are of course specific. The buyer always claims the next expectations of that purchased product:
2. Depending on product quality, consumers need to be satisfied in stipulations of beauty, attraction, taste, shape, design and longevity.

2.2 Quality Control

Quality Control is seen as the agent of Quality Assurance or Total Quality Control. In the garment industry quality control is practiced right from the initial stage of sourcing raw materials to the stage of final finished garment. For textile and apparel industry product quality is calculated in terms of quality and standard of fibers,

yarns, fabric construction, color fastness, surface designs and the final finished garment products. However quality expectations for export are related to the type of customer segments and the retail outlets. Quality control and standards are one of the most important aspects of the content of any job and therefore a major factor in training

2.2.1 Objectives of Total Quality Control

The main object is almost always to maximize the formation of goods within the specified tolerances correctly the first time.

The another object would be to achieve a satisfactory design of the fabric or garment in relation to the label of preference in design, styles, colors, suitability of aspects and fitness of product for the market

2.2.2 The requirements of Quality Control

2.2.3 Quality control function

The first measure for quality control is almost always to understand, establish & take the customers' good requirements. This involves the next steps: -

- Getting customers specifications regarding the quality.
- Referring our past performance.
- Discussing with the Quality Control Department.
- Discussing with typically the Production Department.
- Giving the Feed Back to the customers.
- Receiving the edited quality requirements from the customers.
- Accepting the quality parameters.

1. Test Properties of Yarn

- If routine checks are carried out on yarn select a delivery of general tex (count, denier).
- If incoming yarn is not checked then take a look at the tex (count, denier) of the delivery for samples and only use if it is within acceptable confines.
- Carry out additional appropriate tests concerning yarn e. g. crimp nylon-Crimp Rigidity test. Knit a small sample and make sure that dye is easily to light, washing and perspiration etc.

· Record details from yarn type, supplier, tex (denier, count) etc. and pass advice to knitting home.

2. Knitting Specification

- Record all details required to produce the clothes or garment blanks including chain put down, stitch length as well as any instrument options.
- Record all details of making the trimmings
- Note any difficulties encountered e. g. stitch pattern causing occasional drop stitches. Pass info to making-up room.

3. Making-up Specification

- Record all details of making-up, including the type and count of this sewing thread, and the order of seaming the parts. b)
- Note any difficulties encountered e. g. difficult operation to attach collar.

4. Test for Physical Properties of Garments

- Record the dimensions of the garment as soon as it is completed
- For a fiber of high moisture regain find the weight in correct condition.
- Wash garment and recheck the measurements.
- Liaison of Quality Control with Cost Department
- On completion, supply cost department with all information.
- For the correct tex (count, denier) of yarn, costing may be made directly on sample. For a count which is above or below the average (although within an acceptable tolerance) make an appropriate adjustment to yarn costs and weight.
- Make an allowance for any anticipated extra difficulties, or a higher than normal rate of seconds.

2.2.3 Quality control data generated

Data is provided at each QC factor. This must turn out to be recorded in simple systems to supply visual on-going probes. These records provide the means for employee accountability and designed for rapid feedback intended for management action. -

1. Raw Materials:

1. Shade - checked to be within tolerance from standard pattern.
2. Delivery weights - checked and any limitation claimed.

2. Yarn Checks

1. Count Tests on Staple Fibre Yarns: Check concerning count variability, within cones and relating to deliveries: to turn out to be within tolerance with specification. If coarse, yarn utilisation reduced.

Check on running average.

2. Bulking Tests on Continuous Filament Textured Yarns: Check concerning consistency, and upon Filamentation

3. Condition Checks: Check concerning incorrect condition

4. Yarn wrapping

5. Levelness of yarn (also Buyer levelness).

3. Knitting Machine Settings

1. Yarn tension - leveled and to knitting specification.

2. Distribution - T. O. Depth dials height - set to specification.

3. Loop/course length : Run-in leveled and to specification, positive give food to checked.

4. Take-down tensions - checked for consistency

4. Fabric Parameters, Fabric or Garment Blank Checks

1. Shade as well as appearance correct jacquard trend correct, absence from barrenness.

2. Width normal - (this is only a guide along with grey fabric).

3. Fabric weights per square meter (or essentially weight per predetermined revs) - looked to within patience of specification.

4. Blank weight per dozen to be within tolerance associated with specification.

5. Check fabric for faults and stains.

6. Finishing loss - on-going record of losses concerning scouring etc.

7. Accountability of knitters

5. Sewing Checks

1. Stitches per cm. and thread run-in ratio checked to be within tolerance of specification.

2. Evenness, balance and correct bight, no stitching missed

3. Extensibility and security correct (i.e. no cracking or laddering).
4. Absence of skip stitching.

Accountability of machinis

6. Final Inspection:

1. Shade correct and not varying from one an important part of garment to some other.
2. Cut is actually correct - o. g. neck, collar and sleeves balanced, pockets correct.
3. Measurements within tolerance of specification, weight proper.
4. Appearance proper, patterns matching.
5. Seams finished correctly, absence from miss stitching, cracking and laddering.
6. Accessories correctly applied and working

7. Recovery Inspection

1. Check whether remedial works out satisfactory.
2. Check on volume of give good results successfully recovered.
3. Avoidance of work recycling

8. Product Tests

1. Color fastness in order to agreed agencies: (e. g. washing, rubbing, perspiration, lights) - examined and on-going continuity cards generated, showing score, checked against styles.
2. Stability: Shrinkage, and extension recovery where needed - to be within tolerance in specification
3. Endurance: Abrasion, pilling or snagging - certified where needed. Rating checked against specification.

2.2.4 Quality standards

Quality control and standards are one of the most important aspects of the content of any job and therefore a major factor in training.

By a Quality Standard we mean the establishment of the threshold at which level of severity a defect becomes unacceptable, i.e. a fault. It is the equivalent of tolerances applicable to measurable factors.

Systematic training involves the training of a person in: -

- Basic knowledge
- Correct methods

- Quality standards

Without this last item defective production cannot be prevented.

These standards are established from the Specification and buying sample, etc.

Next step is control of consistency, - i.e. supervision of, and inspection after, each stage of manufacture.

Quality cannot be inspected into a product; it is either there or not. It must be bred into the making of the product by the operative; this is where quality starts. Instructors of trainees are therefore at the controls of quality.

2.2.5 The importance of quality control

It is important that your quality control system set monitors and keeps up in any three of all these phases. If the systems commonly are not being controlled and even kept up you might risk one of the following occurrences:

- Rejection of products, accessories
- Require outside quality control services (extra expenses)
- Degradation of Factory and Brand Value
- Low motivated employees, nobody wants to get blamed
- May cause for a recall
- Delay in production times

When the the right QC in in no way in place it will cost you time along with money hurting your brand name along the way.

2.2.6 How to control quality:

The key step to controlling quality in the textile industry should start at the garments factory and that requires specialized equipment. Textile testing equipment is the most efficient and cost effective way of keeping standards in place through various product line productions. There are additional ways to ensure quality control in the factory and they include:

1. Ensure operators have proper training and use quality sewing materials
2. Understand and follow quality specifications
3. Provide good and bad feedback on products being manufactured
4. Check on work being produced on a daily basis
5. Reference a quality control checklist
6. Use textile testing equipment to maintain quality standards
7. Do not compromise quality under any circumstance

2.3.1 Quality control in fabric section

The quality of the fabric is accountable for quality evaluation with quality control and the responsibility to identify whether a dress can be a position to satisfy the needs of buyers. Generally, sample samples are tested by the customer and according to approved samples. In the fabric the quality is tested to meet the customer's requirements. Quality control functions As soon as the allocation for the Quality Innovation Department of Fabian In-House and Katia Division begins.

Most inspectors are given the responsibility to visit finished garments without adequate training for fabric differences and their causes. The final solution is, of course, both major and minor flaws are provided with actual examples or photographs. This section provides a list of errors and explanations and simplifies the language and judgments used to create visual fabric surveys. Quality control manager can provide this list to inspectors as a practical tool for achieving uniform inspection decisions.

2.3.2 Quality parameters of woven, knitted and non-woven Fabrics:

Generally to test the quality parameters of woven, knitted and non-woven fabric, the fabric must be conditioning at 24 hours in the standard testing atmosphere. It is very important for all types of fabric.

for all types of fabric.

2.3.3 Quality parameters of woven fabrics:

There are some quality parameters of woven fabric

1. Dimensional characteristics:

- Length
- Width
- Thickness.

2. Weight of fabric:

- Weight per unit area.
- Weight per unit length.

3. Fabric strength and extensibility:

- Tensile strength.
- Tearing strength.

4. Threads per inch of fabric:

- Ends per inch.
- Picks per inch.

5. Yarn count:

- Warp count

- Weft count.

6. Crimp:

- Warp crimp
- Weft crimp.

7. Handle:

- Stiffness
- Drape.

8. Crease resistance and crease recovery.

9. Air permeability.

10. Abrasion resistance.

11. Water resistance.

12. Shrinkages.

13. Different fastness properties:

- Fastness to light.
- Fastness to wash.
- Fastness to perspiration.
- Fastness to Rubbing.

2.3.4 Quality parameters of knitted fabrics:

There are some quality parameters of knitted fabric

1. Strength and extensibility.
2. Course density.
3. Wales's density.
4. Lop length.
5. Elasticity.
6. Deformation.

7. Grams per square meter (G.S.M)
8. Yarn count.
9. Design.

2.3.5 Quality parameters of non-woven fabrics:

There are some quality parameters of non-woven fabric

1. Strength and extensibility of fabric.
2. Weight.
3. Thickness.
4. Air permeability.
5. Crease resistance.
6. Stability of washing.
7. Stability of dry cleaning.
8. Dimensional stability.
9. Elasticity.

2.3.6 Fabric Quality Inspection

Regarding clothing industry, it is possible to visit a visual test or raw material (such as fabric, knitting thread, button, trim etc.). It is an important aspect before the production of clothing to avoid fabric due to quality of the fabric and to avoid facing the unexpected loss of production. The quality of a final garment depends on the quality of a fabric when it is obtained as a roll. Even the most outstanding production methods can not compensate for faulty materials. Generally, we assess and evaluate 10% of their rolls based on a four-point system. In this way, we can avoid fabric related quality problems before we are produced.

2.3.7 Fabric Quality Inspection Method

Normally four systems are used for inspection of finished garments.

- a) 4 point system
- b) 10 point system
- c) Graniteville "78" system.
- d) Dallas system.

2.3.8 4- Point inspection system

In this system, how many defect points in 100 sq yards of fabric are identified by inspection? The fabric is supposed to be rejected if the number of defect point is 40 or more in each 100 sq yards of fabric. Allowable defect points may be more than 40 depending upon the price and quality of garments, but it actually comes out by depending on the understanding between buyer and manufacturer. The defect point distribution for different kinds of fault is given the next slide:

Basic principle:

Defect point values should be counted in 100 yd² fabric. If defects point values are 40 or less then it indicates first quality fabric. The grading range is given below:

| Point | grade |
|-------------|----------|
| ≤40 | A |
| Above 40-60 | B |
| Above 60-80 | C |
| Above 80 | Rejected |

2.3.9 Procedure:

- Should select 10% fabric randomly from the fabric received quantity.
- The defects are located, marked and recorded on a frame.
- Fabric defect points are taken based on the following table.

| Length of defect(in inch) | Penalty point |
|---------------------------|---------------|
| Up to 3 inch | 1 |
| Over 3 inch—Up to 6 inch | 2 |
| Over 3 inch—up to 9 inch | 3 |
| Over 9 inch | 4 |
| ≤ 1 inch(holes) | 2 |
| Over 1 inch | 4 |

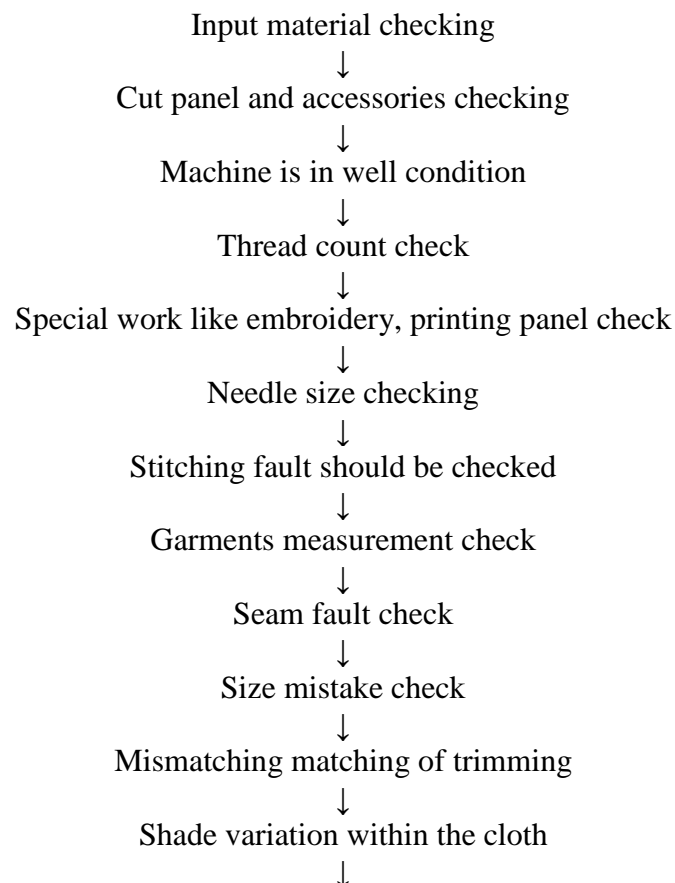
2.3.10 Calculation:

$$\text{Point} / 100 \text{ yds}^2 = \frac{\text{Total Defect Point} \times 3600}{\text{Total length of Fabric} \times \text{Fabric width in inch}}$$

2.4. Sewing section:

From the garment marketplace or item of clothing industry, the team of sewing would be the main division with the production connected with garments. When each of the garments usually are complete to try and do the chopping cut, most of these cutting areas are to help send towards sewing department for producing garment. Various chopping parts in this particular section will be integrated with unique variations of sewing products, threads in addition to needle. Floor in-charge generally maintains a practical method for making perfect apparel easily in addition to accurately. Procedure process to be a process chart on the process connected with stitching connected with garment industry is additionally called practice

2.4.1 Quality control flow chart at sewing section



Wrong placement of interlining
 ↓
 Creased or wrinkle appearance control

2.4.2 All the above processes have discussed in the below table:

| S/L No. | Process | Procedure |
|---------|---|---|
| 01 | Input material check | It is the first process of quality control in sewing section. Here all the input materials should be checked to complete all the sewing processes accurately. |
| 02 | Cutting panel and accessories checking | All the cutting panels and accessories should be checked here to avoid mismatching with the other cutting parts and trimmings. |
| 03 | Checking sewing machine | According to buyers approved sample, right sewing machine should be selected here to complete all the required sewing for the garments. |
| 04 | Sewing thread checking | It's a very important matter in sewing section. Sewing thread should be selected here according to buyers approved sample. |
| 05 | Sewing needle checking | Here, required sizes needle should be selected to complete fault free sewing for the garments. |
| 06 | Embroidery and printing panel checking (If there) | If there's any embroidery or print lies in the garments, then it should be checked by maintaining buyers approved sample. |
| 07 | Stitching fault checking | After making the garments, here garments checked to identify stitch fault free garments. |
| 08 | Seam fault checking | After checking stitch, all the seam of garments must be checked here. |
| 09 | Measurement checking | According to buyer's instruction, garments measurement has to check here. |
| 10 | Shade variation checking | Sometimes various types of shade variation have seen in the garments which should be checked here. |
| 11 | Size mistake checking | For submitting perfect size of garments to the buyer, an extra checking has needed here. |
| 12 | Trimmings checking | According to buyers approved sample, required trimmings of garments should be checked here to make fault free garments. |
| 13 | Interlining checking | Interlining checking should be done here by the quality inspector whether it is perfect or not. |
| 14 | Crease or wrinkle appearance checking | It is the last process of quality control in sewing section, where quality inspector confirms crease or wrinkle free garments. |

2.4.3 Sewing Department:

Checkpoints in the sewing departments are as following.

- **Inline inspection:** The assembly line is usually kept for check pits critical operation. In these checkpoints, partially sewed garments are checked for 100% and in the next process the broken pieces are forwarded. Such checks are used for high quality garments.
- **Traffic light inspection system:** Very low garment manufacturers use this inspection. In this method each operator in this system is given a card for measuring the performance of their quality. The quality tester operator goes and random check for a few pieces and according to the results of the inspection, mark the red or green cards on the following card according to the test criteria.
- **End of line inspection or table checking:** A checker checks completely stitched garment at the end of the line. 100% checking is done here.
- **Audit of the checked pieces:** Very few manufacturers follow this audit procedure but it is very essential checkpoint to assure that only 100% inspected garment are sent to finishing from sewing department. And all defective pieces are repaired before sending to finishing.

2.4.4 Process inspection in sewing line quality inspection

1. Sewing Line quality Check List

- Buyer Approved Sample & Measurement Sheet Check.
- Sample Wise Input Check.
- Buyer Approved Trims Card Check.
- Buyer Approved Sample Wise Style Check.
- All Machine thread Tension Check.
- Style Wise Print & Embroidery Placement Check.
- All Process Measurement Check.
- All Machine Oil Spot Check.
- All Process S.P.I Check as Per Buyer Requirement.
- Input Time Shading, Bundle Mistake & Size Mistake Check.
- Buyer Approved Wise Contrast Color Check.

- As per Buyer Requirement Wise Styling Check.
- All Machine Stitch Tension Balance Properly.

2. Sewing Table inspection

- Style Wise Garments Check.
- All Process Measurement Check...
- Front Part, Back Part, Sleeve & Thread Shading Check.
- S.P.I Check for All Process.
- Print/Embroidery Placement Check.
- Main Label, Care Label, Size Label & Care Symbol Check.
- Size Mistake Check.
- All Process Alter Check.
- Any fabric fault/Rejection Check.

2.5 Quality control in finishing:

In a garment industry finishing section involves with garment washing, checking, final inspection, pressing, packing, etc. Proper finishing process can be improved quality of garments and make on time order shipment. Garments shipment is very much dependable on Garments finishing section. Finishing section add value to the product which attracts customers by the presenting activities of the product according to buyer's requirements.

2.5.1 Machine and equipment used in finishing section:

1. Thread sucker machine
2. Thread Cutter
3. Hand tag Gun
4. Lifter
5. Iron
6. Metal detector
7. Textile cleaning Gun etc.

2.5.2 Process Flow Chart of Garment Finishing:

Finishing input (style, color & size wise)



Initial quality check



Spot Removing



Ironing/Pressing



Inspection



Hang tag



Get up change



Folding



Poly



Bar code (buyer wise sticker)



Metal check



Cartooning/Packaging



Final inspection by buyer

2.5.3 Quality control policy for garment finishing section:

To maintain high quality, garment quality policy must be adopted in the finishing floor. Some essential policies are as follows:

- After trimming the unnecessary thread all garments are being sent to iron section directly.
- In the iron table they are drawing size wise graded patterns of the body and the garments are being ironed conforming to the respective sizes.
- After complete ironing all garments are checked by QC. Only OK garments are sent for 100% measurement, reject garments are segregated and taken away from the finishing floor.
- In this stage, after checking 100% measurement of all bodies, only the OK garments are sent for folding and packing process.
- Top management has appointed one QC to do the hourly checking of all garments.
- QC prepares a report in this regard and put up to AGM of the floor for his review.
- At the end of the day another QC person is doing the day-final and making a report in this respect and keeping record. If the garments are found with problem in the day final; then all the garments are being opened and re-checked.
- At the end, after complete finishing operation of any order they are doing the pre-final or lot pass inspection from the point of view of buyer and making a complete report in his regard maintaining record also. If the result will be found OK only then they will be offering final inspection.
- When the garments pass the pre-final or mock up inspection then all the garments are kept under constant observation.
- In this stage, garment manufacturers are organized final inspection for garments. After completing the final inspection from the buyers representative and they are make final inspection reports. If the reports are OK then the orders are ready for shipment.

2.5.4 Steps of Garments Finishing:

The steps of garments finishing are as follows-

1. Goods Received from Sewing Section:

At first, finished garments are received from sewing section as per order quantity. Good received from sewing section is the first step to finishing section.

2. Thread Sucking by Machine:

In this step extra loose sewing thread are sucking by sucking machine in garments. Threads are suckered by two systems. One by done by hand which is manual system and the other is done by sucking machine.

3. Ironing:

Ironing is a finishing process done by a cloth to heat and pressure with or without steam to remove creases and to impart a flat appearance to garments. Ironing process is also called as pressing process. After completing ironing, garments have to be folded.



Ironing process in Garments

5. Measurement Check by QC:

When ironing process running that time also check measurement of garments. During the ironing process measurement is also check out by the QC.

6. Attach Price Tags and Accessories:

After above process, different types of tags and accessories are attached with the garments as per buyer comment. For an export order, must attach price tags with the garments.

7. Metal Detection:

Garments are passed through into the metal detection m/c for metal check. Now most of the buyer recommended to use metal detector for garments more safety. To use metal detector for kid's item is must.

8. Folding:

Garments are folded according to buyer directions in a standard area. There are fore types of folding in garments. They are as follows-

- a. Stand up
- b. Semi stand up
- c. Flat back
- d. Hanger pack.

8. Packing:

After folding garments are ready for packing. The size of polythene is vary according to the size, garments ratio. Before packing it is needed to ensure the placement of sticker in proper place.



Garments Packing Process

9. Assortment:

After completing the packing, it must be placed the garments in a predetermined packed by sorting according to the size and color is called assortment.

10. Cartooning:

At last cartooning is done according to buyer comment into the inner boxes and is properly warped by the scotch tape. Some information like carton box no, size, shipping mark, destination are printed on the cartoon.

11. Final Inspection:

Final inspection is an important part and last step of garments finishing. Normally final inspection is made by buyer. Buyer checks the garments according some rules like Accepted Quality Level (AQL).

Methodology

3.1 Location of the study:

The study has mainly on primary data. Mixed method has been adopted. Information has been collected from worker ; however the unit of analysis is individual . Secondary sources of information have also used. The research has been conducted at fair trade group (A Sister concern of ABA group) and Aman tex ltd

3.2 Sample size and Sampling technique:

A total of a line have been selected for sample .factory is composed of 3500 people The research has been conducted. It has been selected through consultation with quality department and sewing section authority. In here are 6 day purposively selected as sample for data analysis in qualitative method.

3.3 Criteria of sample selection:

Sample has been selected purposively following two criteria:

- Worker aged between 18-30 years
- Have been working at industry at least for last 2 years

3.4 Data Collection:

Data sheets were collected for quality department of sewing and finishing section, some data are collected from quality table end of the line of the garments production floor.

3.5 Defects per hundred unites calculation :

- “**Defect per Hundred Units**”. It means number of defeats found or detected per 100 garments.
- Defects per hundred unite = $\text{Total Alter pcs} * 100 / \text{Total garments}$
- In this analysis all data collect in a **End Line Inspection Report** sheets

3.6 Data collection period:

6 days of march 2018

3.7 Limitations of the thesis:

Most of the research study has some limitations. As a researcher, this research also has some limitations. Researcher wants to outlines some the limitations of the study:

- Methodological limitations: Researcher has used mixed methodology in conducting this research. Researcher believes naturalistic approach is appropriate for this research investigation. At the same it is believed that quantitative and mixed method can also explain the topic.
- Time : Time is very important factor in conducting any research. Researcher believes that for a good, neutral research time frame is very essential. But in this research researcher only gets up to 5-6 month. This time is not enough for conducting such a research.
- Budget : Researcher doesn't get any money from department. All the expenses are beard by the researcher himself. As a student it seems a little burden for the researcher. He had to cut some essential to maintain his budget.
- Due to the shortage of time we could not get at depth knowledge of the quality.
- Sufficient records, facts and figures are not available.

3.8 Data Analysis

3.2.1 knitting data from sewing section :

a) Aman Tex Ltd

Table 1

| Order No: AO17-17-792 | | | | Style No: S18AFLPOWO2 | | | | Color: R1 | | | |
|----------------------------|-------|-------|-------|-----------------------|-------|-------|-------|------------------|-------|-------|-------|
| Buyer: SPORTMASTER | | | | | | | | Date: 24-09-2017 | | | |
| Defects Name | Hour | | | | | | | | | | |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | Total |
| Broken stitch | | | | | | | | | 1 | 4 | 5 |
| Button/snap/ Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | 2 | 1 | 1 | 1 | 1 | 1 | | | | 7 |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | | | | | | | | |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Raw edge | | | | | | | | | | | |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | 2 | 2 | | 4 | 4 | 2 | 14 |
| Skip stitch | 1 | | | | | | | | | | 1 |
| Shading | | | | | | | | | | | |
| Strip not match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | | | 1 | 1 | 2 | | | 2 | 1 | | 7 |
| Un even | | | | | | | | | | | |

| | | | | | | | | | | | |
|-----------------------|----|----|----|----|----|----|----|-----|-----|-----|--------|
| Uncut thread | | 5 | 5 | 2 | 4 | 3 | 2 | 5 | 5 | | 31 |
| Waviness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Rocket | | | | | | | | | | | |
| Pleat | | | | | | | | 5 | 3 | | 8 |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | | | | | |
| Dirty spot | | | | | | | | | | | |
| Rejects | | | | | | | | 2 | 1 | 1 | 4 |
| Others | | 2 | | | | | | | | 2 | 4 |
| | | | | | | | | | | | |
| Total Inspected Qty | 75 | 80 | 80 | 85 | 85 | 90 | 90 | 172 | 174 | 172 | 1104 |
| Total OK Goods | 75 | 80 | 80 | 85 | 85 | 90 | 90 | 170 | 173 | 171 | 1100 |
| Total Defectives Qty | 5 | 8 | 4 | 6 | 8 | 5 | 6 | 13 | 12 | 12 | 81 |
| Rejects Qty | | | | | | | | 2 | 1 | 1 | 4 |
| DHU% | | | | | | | | | | | 7.33% |
| QC pass% | | | | | | | | | | | 92.63% |

Table 2

| | | | | | | | | | | | |
|------------------------|-------|-------|-------|-------------------|-------|-------|-------|-------------------|-------|-------|-------|
| Order No: 30A05O95 | | | | Style No: TAZ TEE | | | | Color: GREEN DARK | | | |
| Buyer: H&M | | | | | | | | Date: 26-01-18 | | | |
| Defects Name | Hour | | | | | | | | | | |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | Total |
| Broken stitch | | | 1 | | 2 | 2 | 1 | 1 | | | 7 |
| Button/snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |

| | | | | | | | | | | | |
|--------------------------|--|---|----|----|----|----|----|----|--|--|--------|
| Open seam | | | | | | | | | | | |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | 1 | 2 | 1 | 3 | 5 | | | | 12 |
| Raw edge | | | | | | | | | | | |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | | | | | | | |
| Skip stitch | | | 3 | 2 | 3 | 2 | 1 | | | | 11 |
| Shading | | | | | | | | | | | |
| Strip not match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | | | | 1 | 2 | | | | | | 3 |
| Un even | | 1 | | 1 | | 3 | 1 | | | | 6 |
| Uncut thread | | | | | | | | | | | |
| Waviness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Rocket | | | | | | | | | | | |
| Pleat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | 1 | 2 | 4 | 5 | 4 | 3 | | | | 19 |
| Dirty spot | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| Rejects | | | | | | | | | | | |
| | | | | | | | | | | | |
| Total Inspected Qty | | | 15 | 40 | 60 | 70 | 70 | 45 | | | 300 |
| Total OK Goods | | | 15 | 40 | 60 | 70 | 70 | 45 | | | 300 |
| Total Defectives Qty | | | 3 | 6 | 12 | 12 | 13 | 11 | | | 58 |
| Rejects Qty | | | | | | | | | | | |
| DHU% | | | | | | | | | | | 19.33% |
| QC pass% | | | | | | | | | | | 80.67% |

Table 3

| Order No: 274274 | | | | Style No: RONNY | | | | Color: GERU | | | |
|----------------------------|-------|-------|-------|-----------------|-------|-------|------------------|-------------|-------|-------|-------|
| Buyer: H&M | | | | | | | Date: 27-01-2018 | | | | |
| Defects Name | Hour | | | | | | | | | | Total |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | | 1 | | | 1 | 1 | 1 | 2 | | | 6 |
| Button/snap/ Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | 2 | 2 | 3 | 1 | | 1 | | 1 | | | 10 |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | 1 | 1 | 1 | | | | | | | | 3 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | 1 | 1 | | 2 | 1 | 1 | 1 | 1 | | | 8 |
| Raw edge | 1 | 1 | | 3 | 2 | 1 | 1 | | | | 9 |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | | | | | | | |
| Skip stitch | 2 | 1 | | | | | | | | | 3 |
| Shading | | | | | | | | | | | |
| Strip not match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | | 1 | 2 | 1 | 1 | 1 | 1 | 2 | | | 9 |
| Un even | | 1 | 1 | 2 | 3 | 2 | 1 | 2 | | | 12 |
| Uncut thread | 2 | 5 | 5 | 4 | 5 | 5 | 5 | 5 | | | 36 |
| Waviness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |

| | | | | | | | | | | | |
|----------------------|----|-----|-----|-----|-----|-----|-----|-----|--|--|-------|
| Rocket | | | | | | | | | | | |
| Pleat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | | | 2 | 1 | | | | | | 3 |
| Dirty spot | | | | | | | | | | | |
| Others | 1 | | | 1 | 3 | 1 | | 1 | | | 7 |
| Rejects | | | | | | | | | | | |
| | | | | | | | | | | | |
| Total Inspected Qty | 90 | 160 | 150 | 140 | 150 | 170 | 100 | 110 | | | 1070 |
| Total OK Goods | 90 | 160 | 150 | 140 | 150 | 170 | 100 | 110 | | | 1070 |
| Total Defectives Qty | 10 | 14 | 12 | 16 | 17 | 13 | 10 | 14 | | | 106 |
| Rejects Qty | | | | | | | | | | | |
| DHU% | | | | | | | | | | | 9.90% |
| QC pass% | | | | | | | | | | | 90.1% |

Table 4

| | | | | | | | | | | | |
|----------------------------|-------|-------|-------|------------------|-------|-------|-------|-------------------------|-------|-------|-------|
| Order No: 272275 | | | | Style No: LIMA | | | | Color: BLUCRCDDISH DARK | | | |
| Buyer: H&M | | | | Date: 28-01-2018 | | | | | | | |
| Defects Name | Hour | | | | | | | | | | |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | Total |
| Broken stitch | 1 | 1 | | 1 | | 1 | | 1 | | 1 | 6 |
| Button/snap/ Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | 4 | 2 | 1 | | | 2 | | | 1 | | 10 |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | | 1 | | 1 | | | | 2 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Raw edge | | | | | | | | | | | |
| Reverse | 5 | 2 | 1 | 1 | | | 1 | | | | 10 |
| Slanted | | | | | | | | | | | |
| Skip stitch | | | | | 2 | 1 | | | | 1 | 4 |
| Shading | | | | | | | | | | | |

| | | | | | | | | | | | |
|--------------------------|----|----|----|----|-----|----|-----|-----|-----|-----|--------|
| Strip not match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | 5 | 2 | 1 | 2 | 1 | | 1 | 1 | | 2 | 15 |
| Un even | | | | | | | | | | | |
| Uncut thread | 1 | 2 | 3 | 5 | 3 | 7 | 5 | 4 | 8 | 7 | 45 |
| Waviness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong placement | | | 2 | | | | | | | | 2 |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Rocket | | | | | | | | | | | |
| Pleat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | 1 | 1 | 2 | 1 | | 5 |
| Dirty spot | | | | | | | | | | | |
| Others | | | | | | | 1 | 1 | 1 | | 3 |
| Rejects | | | | | | | | | | | |
| | | | | | | | | | | | |
| Total Inspected Qty | 20 | 25 | 70 | 90 | 110 | 70 | 120 | 110 | 130 | 110 | 855 |
| Total OK Goods | 20 | 25 | 70 | 90 | 110 | 70 | 120 | 110 | 130 | 110 | 855 |
| Total Defectives Qty | 16 | 9 | 8 | 10 | 7 | 12 | 10 | 9 | 2 | 2 | 102 |
| Rejects Qty | | | | | | | | | | | |
| DHU% | | | | | | | | | | | 11.92% |
| QC pass% | | | | | | | | | | | 88.08% |

Table 5

| Order No: 272275 | | | Style No: LIMA | | | | Color: GERU | | | | |
|-----------------------------|-------|-------|------------------|-------|-------|-------|-------------|-------|-------|-------|-------|
| Buyer: H&M | | | Date: 29-01-2018 | | | | | | | | |
| Defects Name | Hour | | | | | | | | | | |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | Total |
| Broken stitch | 1 | | 1 | | | | | | | | 2 |
| Button/snap/ Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | 1 | 1 | | | | | | | | | 2 |
| Label fault | | | | | | | | | | | |
| Needle mark | | 1 | 1 | | | | | | | | 2 |
| Open seam | | | | | | | | | | | |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Raw edge | | | | | | | | | | | |
| Reverse | | 1 | | | | | | | | | 1 |
| Slanted | | | | | | | | | | | |
| Skip stitch | 2 | 1 | | | | | | | | | 3 |
| Shading | | | | | | | | | | | |
| Strip not match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | | | | | | | | | | | |
| Un even | | | | | | | | | | | |
| Uncut thread | 4 | 6 | 7 | | | | | | | | 17 |
| Waviness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |

| | | | | | | | | | | | |
|----------------------|-----|-----|-----|--|--|--|--|--|-----|-----|--------|
| Rocket | | | | | | | | | | | |
| Pleat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | 1 | | 1 | | | | | | | | 2 |
| Dirty spot | | | | | | | | | | | |
| Others | | | 1 | | | | | | | | 1 |
| Rejects | | | | | | | | | | | |
| | | | | | | | | | | | |
| Total Inspected Qty | 130 | 130 | 135 | | | | | | 855 | 395 | 1250 |
| Total OK Goods | 130 | 130 | 135 | | | | | | 855 | 395 | 1250 |
| TOTAL Defectives Qty | 9 | 10 | 11 | | | | | | 102 | 30 | 132 |
| Rejects Qty | | | | | | | | | | | |
| DHU% | | | | | | | | | | | 10.56% |
| QC pass% | | | | | | | | | | | 89.44% |

Table 6

| | | | | | | | | | | | |
|------------------------|-------|-------|-------|-------------------------|-------|-------|-------|------------------|-------|-------|-------|
| Order No: 265542 | | | | Style No: BOBV-NECK TEE | | | | Color: WHITE | | | |
| Buyer: H&M | | | | | | | | Date: 30-01-2018 | | | |
| Defects Name | Hour | | | | | | | | | | |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | Total |
| Broken stitch | 3 | 3 | | | 1 | 1 | | | 1 | | 9 |
| Button/snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | 2 | | 1 | 3 |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut damage | | | | | | | | | | | |
| Improper tuck | | 1 | 1 | 1 | 1 | 3 | | 2 | 5 | 3 | 17 |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | 1 | | | | | | | | 1 |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | 1 | | | | | | | 1 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Raw edge | | 1 | | | | 1 | 1 | | 2 | | 5 |
| Reverse | | | | | | | | | | | |
| Slanted | 1 | 1 | | | | | 2 | | | | 4 |
| Skip stitch | | 4 | 1 | 7 | | 6 | | 1 | 1 | | 20 |
| Shading | | | | | | | | | | | |
| Strip not match | | | | | | | | | | | |

| | | | | | | | | | | | |
|--------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------|
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | | | | | | | | | | | |
| Un even | 1 | 2 | 3 | 6 | | 3 | 2 | 2 | 1 | 2 | 22 |
| Uncut thread | 4 | 5 | 4 | 4 | 4 | 5 | 5 | 5 | 7 | 5 | 48 |
| Waviness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Rocket | | | | | | | | | | | |
| Pleat | | | 4 | 1 | 2 | 1 | 2 | | | 2 | 12 |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | | | | | |
| Dirty spot | | | 2 | 1 | 2 | 2 | | 2 | 2 | 3 | 14 |
| Others | | | | | | | | | | | |
| Rejects | | | | | | | | | | | |
| | | | | | | | | | | | |
| Total Inspected Qty | 100 | 120 | 130 | 120 | 130 | 140 | 140 | 130 | 170 | 160 | 1340 |
| Total OK Goods | 100 | 120 | 130 | 120 | 130 | 140 | 140 | 130 | 170 | 160 | 1340 |
| Total Defectives Qty | 9 | 14 | 15 | 25 | 14 | 16 | 14 | 13 | 19 | 17 | 156 |
| Rejects Qty | | | | | | | | | | | |
| DHU% | | | | | | | | | | | 11.64% |
| QC pass% | | | | | | | | | | | 88.36 |

Table 7

| Order No: 223256 | | | | Style No: LEE LONG | | | | Color: WHITE | | | |
|-----------------------------|-------|-------|-------|--------------------|-------|-------|------------------|--------------|-------|-------|-------|
| Buyer: H&M | | | | | | | Date: 22-10-2017 | | | | |
| Defects Name | Hour | | | | | | | | | | |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | Total |
| Broken stitch | 2 | 1 | | | | | | | | | 3 |
| Button/snap/ Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | 1 | | | | | | | 1 |
| Cut damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | | | | | | | | |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Raw edge | | | | | | | | | | | |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | | | | | | | |
| Skip stitch | | | | | | | | | | | |
| Shading | | | | | | | | | | | |
| Strip not match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | | 3 | 1 | | 1 | | | | | | 5 |
| Un even | | | | | | | | | | | |
| Uncut thread | | | | | 2 | | | | | | 2 |
| Waviness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Rocket | | | | | | | | | | | |

| | | | | | | | | | | | |
|----------------------|-----|-----|-----|-----|-----|--|--|--|--|--|--------|
| Pleat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | | | | | |
| Dirty spot | 1 | | | | | | | | | | 1 |
| Others | | | | | | | | | | | |
| Rejects | | | | | | | | | | | |
| | | | | | | | | | | | |
| Total Inspected Qty | 100 | 110 | 116 | 100 | 111 | | | | | | 537 |
| Total OK Goods | 100 | 110 | 116 | 100 | 111 | | | | | | 537 |
| Total Defectives Qty | 3 | 4 | 1 | 3 | 4 | | | | | | 15 |
| Rejects Qty | | | | | | | | | | | |
| DHU% | | | | | | | | | | | 2.79% |
| QC pass% | | | | | | | | | | | 97.21% |

Summary of Reports (Aman Tex Ltd.) in sewing section.

| Date | Buyer | Inspected Qty | Defects | | | | | | | | | | | | | | | | | | |
|----------|--------------|---------------|---------------|-------------|---------|-------------|---------|-------------|------|-----------|---------|----------|------------|---------|-------------|---------------|-----------|----------|------------|-------------|---------|
| | | | Broken stitch | Label fault | Slanted | Skip stitch | Up down | Uncut tread | peat | Puckering | Un even | Oil spot | Join stich | Reverse | Needle mark | Improper tuck | Open edge | Raw edge | Dirty spot | Needle hole | Rejects |
| 24-09-17 | sport master | 1104 | 5 | 7 | 14 | 1 | 7 | 31 | 8 | | | | | | | | | | | 4 | 4 |
| 26-01-18 | H&M | 300 | 7 | | | 11 | 3 | | | 12 | 6 | 19 | | | | | | | | | |
| 27-01-18 | H&M | 1070 | 6 | | | 3 | 9 | 36 | | 8 | 12 | 3 | | | | | | | | | 7 |
| 28-01-18 | H&M | 855 | 6 | | | 4 | 15 | 45 | | | | 5 | 10 | 10 | | | | | | | 3 |
| 29-01-18 | H&M | 1250 | 2 | | | 3 | | 17 | | | | 2 | 2 | 1 | 2 | | | | | | 1 |
| 30-01-18 | H&M | 1340 | 09 | 1 | 4 | 20 | | 48 | 12 | | 22 | | | | | 17 | 1 | 5 | 14 | | |
| 22-10-17 | H&M | 537 | 3 | | | | 5 | 2 | | | | | | | | | | | 1 | 1 | |
| Total | 6456 | 516 (7.95%) | | | | | | | | | | | | | | | | | | | |
| | | 38 | 8 | 18 | 42 | 39 | 17 9 | 20 | 20 | 40 | 29 | 12 | 11 | 2 | 17 | 1 | 5 | 15 | 1 | 4 | 15 |
| Defect % | | 7.36 | 1.55 | 3.88 | 8.13 | 7.55 | 34.68 | 3.87 | 3.87 | 7.75 | 5.62 | 2.32 | 2.13 | 0.38 | 3.29 | 0.19 | 0.96 | 2.90 | 0.19 | 0.77 | 2.90 |

Here is the highest defects % is 34.89 that is uncut thread

3.2.2 Woven data from sewing section :

b)Fair Trade group

TABLE :1
BEATS FASHION LTD

Agent :ABA
Date :14-03-2018
Buyer :JULES

Ends Line Inspection Report

Item :711266
Inspector :SHANAUR
PO/Art :325459
Line :N-12

Style :SHORT PANT

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|------------------|------|------|------|------|------|------|-----|------|------|------|-------|---------|
| Total Received | 100 | 120 | 140 | 120 | 140 | 120 | 110 | 140 | 110 | 130 | 1260 | |
| | 100 | 220 | 360 | 480 | 620 | 770 | 990 | 1130 | 1130 | 1260 | | |
| Ok | 96 | 116 | 135 | 116 | 135 | 598 | 116 | 106 | 135 | 135 | | |
| | 96 | 212 | 247 | 453 | 598 | 714 | 820 | 995 | 1090 | 1215 | | |
| Alter | 4 | 4 | 5 | 4 | 4 | 5 | 4 | 5 | 5 | 5 | 45 | 3.57% |
| | 4 | 8 | 13 | 17 | 22 | 26 | 30 | 36 | 40 | 45 | | |
| Alter Rectified | 4 | 4 | 5 | 4 | 5 | 4 | 4 | 5 | 5 | 5 | 45 | 3.57% |
| | 4 | 8 | 13 | 17 | 22 | 26 | 30 | 35 | 40 | 45 | | |
| Total Ok | 100 | 120 | 240 | 120 | 140 | 120 | 110 | 140 | 140 | 135 | | |
| | 100 | 220 | 360 | 480 | 620 | 740 | 850 | 990 | 130 | 1260 | | |
| Bar tack | BR 1 | | BR 1 | BR1 | BR 1 | BR1 | | BR 2 | BR 1 | | 8 | 0.63% |
| Loop | LS1 | LS 1 | LS 2 | | LS 2 | | LS2 | LS 2 | LS2 | LS 1 | 13 | 1.03% |
| Mouth | | OP 1 | | OP 1 | | OP 1 | | | | DS 2 | 5 | 0.39% |
| Hem | DS1 | | | | | DS1 | TL1 | | OL | | 5 | 0.39% |
| Inseam | | | TL1 | SK1 | | SK1 | | | | | 3 | 0.23% |
| Side Seam | | DS1 | | | OP2 | OP1 | | | | | 4 | 0.32% |
| Waist | | | | | | | | SK1 | | | 2 | 0.15% |
| Back | | TL1 | | TL2 | | IS1 | | | | | 3 | 0.23% |
| Front | | | | | | | | | | | 2 | 0.15% |
| L/Chief sing | | | IS 1 | | | | | OP1 | | | | |
| Chief Controller | | | | | | | | | | | | |

| | | | | | | | | | | | | | | | |
|---|------------------|----|----------------|----|-------------------|---|---------------|----|---------------|---|----------------|----|----------------|----|--------------|
| B | Brocken stitch | E | Embroidery | IS | Incomplete stitch | N | Needle Mark | P | Puckering | S | Skip Stitch | TH | Thread Mistake | V | Visible Edge |
| B | Bubbling | F | Fabric fault | I | Ink mark | N | Narrow Stitch | R | Run Of Stitch | S | Slanted Pocket | U | Uneven Stitch | W | Weave Zipper |
| B | Bar tack missing | G | Gathering | L | Level mistake | o | Oil Mark | R | Raw Edge | T | Twisted | UP | Uneven Point | W | M |
| D | Damaged | HP | High law PKT | L | Loop Slanted | O | Open Stitch | RJ | Reject | T | Tension Tight | UI | Uneven Lob | WS | |
| D | Dirty | H | High low waist | M | Missing Stich | O | Over Stitch | S | Shading | T | Tension Loose | U | Uneven width | W | Widith |

TABLE :2
BEATS FASHION LTD

Ends Line Inspection Report

Agent :ABA
Date :15-03-2018
Buyer :JULES
Style :SHORT PANT

Item :711266
inspector : SHANAUR
PO/Art :325459
line :N-12

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|------------------|-----------|------|------|------|------|------|------|-----|------|------|-------|---------|
| Total Received | 100 | 100 | 110 | 120 | 100 | 130 | 120 | 120 | 120 | 140 | 1140 | |
| | 100 | 200 | 300 | 410 | 530 | 640 | 710 | 836 | 1000 | 1040 | | |
| Ok | 96 | 96 | 95 | 110 | 114 | 117 | 116 | 115 | 135 | | | |
| | 96 | 182 | 277 | 320 | 415 | 532 | 623 | 836 | 951 | 1086 | | |
| Alter | 4 | 4 | 4 | 5 | 4 | 6 | 4 | 4 | 5 | 5 | 44 | 3.85% |
| | 4 | 8 | 12 | 17 | 19 | 22 | 25 | 34 | 39 | 44 | | |
| Alter Rectified | 4 | 4 | 4 | 5 | 4 | 6 | 4 | 4 | 5 | 5 | 44 | 3.85% |
| | 4 | 8 | 12 | 17 | 19 | 22 | 25 | 34 | 39 | 44 | | |
| Total Ok | 100 | 100 | 110 | 120 | 100 | 130 | 120 | 120 | 120 | 140 | | |
| | 100 | 200 | 300 | 410 | 530 | 640 | 710 | 836 | 1000 | 1040 | | |
| L/Chief sing | Bar tack | BR 1 | | BR 1 | BR1 | BR 1 | BR1 | | BR 2 | BR 1 | 9 | 0.78% |
| | Loop | LS1 | LS 1 | LS 2 | | LS 2 | | LS2 | LS 2 | LS 2 | 12 | 1.05% |
| | Mouth | | OP 1 | | OP 1 | | OP 1 | | | DS 2 | 6 | 0.52% |
| | Hem | DS1 | | | | | DS1 | TL1 | | OL | 8 | 0.70% |
| | Inseam | | | TL1 | SK1 | | SK1 | | | | 2 | 0.17% |
| | Side Seam | | DS1 | | | OP2 | OP1 | | | | 2 | 0.17% |
| | Waist | | | | | | | | SK1 | | | |
| | Back | | TL1 | | TL2 | | IS1 | | | | 2 | 0.26% |
| | Front | | | SK1 | | | | | OP1 | | 3 | 0.17% |
| Chief Controller | | | | | | | | | | | | |

| B | B | E | IS | N | P | S | SK | TH | V | Visibl | | | | | |
|---|------------------|----|----------------|----|-------------------|---|---------------|----|---------------|--------|----------------|----|----------------|----|--------------|
| B | Brocke | E | Embroidery | IS | Incomplete stitch | N | Needle Mark | P | Puckering | S | Skip Stitch | TH | Thread Mistake | V | Visible Edge |
| B | Bubbling | F | Fabric fault | I | Ink mark | N | Narrow Stitch | R | Run Of Stitch | S | Slanted Pocket | U | Uneven Stitch | W | Weave Zipper |
| B | Bar tack missing | G | Gathering | L | Level mistake | o | Oil Mark | R | Raw Edge | T | Twisted | UP | Uneven Point | W | M |
| D | Damag | HP | High law PKT | L | Loop Slanted | O | Open Stitch | RJ | Reject | T | Tension Tight | UI | Uneven Lob | WS | |
| D | Dirty | H | High low waist | M | Missing Stich | O | Over Stitch | S | Shading | T | Tension Loose | U | Uneven width | W | Width |

TABLE :3
BEATS FASHION LTD.

Ends Line Inspection Report

Agent :ABA
Date :17-03-2018
Buyer :JULES

Factory :
BEATS
FASHION
LTD
Item
:711266
Inspector :
SHANAUR
PO/Art
:325459
line :N-
12

Style :SHORT PANT

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks | |
|------------------|-----------|------|------|------|------|------|-----|------|------|------|-------|---------|-------|
| Total Received | 100 | 110 | 120 | 110 | 110 | 110 | 120 | 120 | 110 | 1130 | 1130 | | |
| | 100 | 210 | 330 | 540 | 540 | 650 | 770 | 890 | 1000 | 105 | | | |
| Ok | 95 | 105 | 116 | 105 | 96 | 105 | 116 | 115 | 105 | 1053 | 47 | | |
| | 95 | 200 | 302 | 432 | 532 | 622 | 765 | 853 | 1083 | 5 | | | |
| Alter | 5 | 5 | 4 | 5 | 4 | 5 | 4 | 5 | 5 | 5 | 47 | 3.85% | |
| | 10 | 10 | 14 | 19 | 24 | 29 | 32 | 37 | 42 | 47 | | | |
| Alter Rectified | 5 | 5 | 4 | 5 | 4 | 5 | 4 | 5 | 5 | 5 | | 3.85% | |
| | 10 | 10 | 14 | 19 | 24 | 29 | 32 | 37 | 42 | 47 | | | |
| Total Ok | 100 | 110 | 120 | 110 | 110 | 110 | 120 | 120 | 110 | 1130 | | | |
| | 100 | 210 | 330 | 540 | 540 | 650 | 770 | 890 | 1000 | 1050 | | | |
| L/Chief sing | Bar tack | BR 1 | | BR 1 | BR1 | BR 1 | BR1 | | BR 2 | BR 1 | 6 | 0.53% | |
| | Loop | LS1 | LS 1 | LS 2 | | LS 2 | | LS2 | LS 2 | LS2 | LS 1 | 11 | 0.97% |
| | Mouth | | OP 1 | | OP 1 | | | OP 1 | | | DS 2 | 3 | 0.23% |
| | Hem | DS1 | | | | | | DS1 | TL1 | | OL | 8 | 0.70% |
| | Inseam | | | TL1 | SK1 | | | SK1 | | | | 4 | 0.35% |
| | Side Seam | | DS1 | | | | OP2 | OP1 | | | | 6 | 0.53% |
| | Waist | | | | | | | | SK1 | | | 2 | 0.17% |
| | Back | | TL1 | | TL2 | | | IS1 | | | | 5 | 0.44% |
| Front | | | SK1 | | | | | | OP1 | | 2 | 0.17% | |
| Chief Controller | | | | | | | | | | | | | |

| B | B | E | Embroidery | IS | Incomplete stitch | N | Needle Mark | P | Puckering | S | Skip Stitch | TH | Thread Mistake | V | Visible Edge |
|---|------------------|----|----------------|----|-------------------|---|---------------|----|---------------|---|----------------|----|----------------|----|--------------|
| B | Brocken stitch | F | Fabric fault | I | Ink mark | N | Narrow Stitch | R | Run Of Stitch | S | Slanted Pocket | U | Uneven Stitch | W | Weave Zipper |
| B | Bar tack missing | G | Gathering | L | Level mistake | o | Oil Mark | R | Raw Edge | T | Twisted | UP | Uneven Point | W | M |
| D | Damag e | HP | High law PKT | L | Loop Slanted | O | Open Stitch | RJ | Reject | T | Tension Tight | UI | Uneven Lob | WS | |
| D | Dirty | H | High low waist | M | Missing Stich | O | Over Stitch | S | Shading | T | Tension Loose | U | Uneven width | DS | Widith |

TABLE :4
BEATS FASHION LTD

Ends Line Inspection Report

Agent :ABA
Date :18-03-2018
Buyer :JULES

Factory :
BEATS
FASHION
Item
:711266
inspector :
SHANAUR
PO/Art
:325459
line :N-
12

Style :SHORT PANT

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks | |
|--------------------|-----------|------|------|------|------|------|------|-----|------|------|-------|---------|-------|
| Total Received | 120 | 110 | 100 | 130 | 120 | 143 | 110 | 110 | 120 | 130 | 1150 | | |
| | 120 | 220 | 320 | 430 | 512 | 521 | 717 | 863 | 917 | 1150 | | | |
| Ok | 115 | 105 | 95 | 105 | 116 | 120 | 117 | 110 | 115 | 125 | | | |
| | 115 | 221 | 316 | 415 | 502 | 502 | 863 | 978 | 978 | 1103 | | | |
| Alter | 5 | 4 | 5 | 4 | 5 | 4 | 5 | 4 | 5 | 5 | 47 | 4.08% | |
| | 5 | 9 | 14 | 19 | 23 | 26 | 31 | 37 | 42 | 47 | | | |
| Alter Rectified | 5 | 4 | 5 | 4 | 5 | 4 | 5 | 4 | 5 | 5 | | 4.08% | |
| | 5 | 9 | 14 | 19 | 23 | 26 | 31 | 37 | 42 | 47 | | | |
| Total Ok | 120 | 110 | 100 | 130 | 120 | 143 | 110 | 110 | 120 | 130 | | | |
| | 120 | 220 | 320 | 430 | 512 | 521 | 717 | 863 | 917 | 1150 | | | |
| L/Chief Controller | Bar tack | BR 1 | | BR 1 | BR1 | BR 1 | BR1 | | BR 2 | BR 1 | 9 | 0.78% | |
| | Loop | LS1 | LS 1 | LS 2 | | LS 2 | | LS2 | LS 2 | LS2 | LS 1 | 12 | 1.04% |
| | Mouth | | OP 1 | | OP 1 | | OP 1 | | | | DS 2 | 5 | 0.43% |
| | Hem | DS1 | | | | | DS1 | TL1 | | OL | | 5 | 0.17% |
| | Inseam | | | TL1 | SK1 | | SK1 | | | | | 2 | 0.52% |
| | Side Seam | | DS1 | | | OP2 | OP1 | | | | | 6 | 0.17% |
| | Waist | | | | | | | | SK1 | | | 2 | 0.52% |
| | Back | | TL1 | | TL2 | | IS1 | | | | | 4 | 0.34% |
| Front | | | SK1 | | | | | OP1 | | | 3 | 0.26% | |
| L/Chief sing | | | | | | | | | | | | | |
| Chief Controller | | | | | | | | | | | | | |

| B | B | E | IS | N | P | S | SK | TH | V | Visibl | | | | | |
|---|------------------|----|----------------|----|-------------------|---|---------------|----|---------------|--------|----------------|----|----------------|-----|--------------|
| B | Brocke | E | Embroidery | IS | Incomplete stitch | N | Needle Mark | P | Puckering | SK | Skip Stitch | TH | Thread Mistake | V | Visible Edge |
| B | Bubbling | F | Fabric fault | I | Ink mark | N | Narrow Stitch | R | Run Of Stitch | S | Slanted Pocket | U | Uneven Stitch | W | Weave Zipper |
| B | Bar tack missing | G | Gathering | L | Level mistake | o | Oil Mark | R | Raw Edge | T | Twisted | UP | Uneven Point | W | W |
| D | Damage | HP | High law PKT | L | Loop Slanted | O | Open Stitch | RJ | Reject | T | Tension Tight | UI | Uneven Lob | WS | |
| D | Dirty | H | High low waist | M | Missing Stich | O | Over Stitch | S | Shading | T | Tension Loose | U | Uneven width | Wid | Widith |

TABLE :5
BEATS FASHION LTD

Ends Line Inspection Report

Agent :ABA
Date :19-03-2018
Buyer :JULES

Factory :
BEATS
FASHION
LTD
Item
:711266
inspector :
SHANAUR
PO/Art
:325459
line :N-
12

Style :SHORT PANT

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks | |
|-----------------------|-----------|------|------|------|------|------|-----|------|------|------|-------|---------|-------|
| Total Received | 100 | 110 | 120 | 110 | 120 | 110 | 120 | 110 | 120 | 110 | | | |
| | 100 | 210 | 330 | 440 | 560 | 790 | 900 | 1020 | 1020 | 1130 | | | |
| Ok | 95 | 105 | 115 | 105 | 115 | 105 | 115 | 106 | 106 | | | | |
| | 95 | 200 | 315 | 420 | 535 | 641 | 756 | 862 | | | | | |
| Alter | 5 | 5 | 5 | 4 | 5 | 4 | 5 | 4 | 5 | 5 | 46 | 4.07% | |
| | 5 | 10 | 15 | 19 | 24 | 31 | 34 | 37 | 42 | 44 | | | |
| Alter Rectified | 5 | 5 | 5 | 4 | 5 | 4 | 5 | 4 | 5 | 5 | 46 | 4.07% | |
| | 5 | 10 | 15 | 19 | 24 | 31 | 34 | 37 | 42 | 44 | | | |
| Total Ok | 100 | 110 | 120 | 110 | 120 | 110 | 120 | 110 | 120 | 110 | | | |
| | 100 | 210 | 330 | 440 | 560 | 790 | 900 | 1020 | 1020 | 1130 | | | |
| L/Chief Controller | Bar tack | BR 1 | | BR 1 | BR1 | BR 1 | BR1 | | BR 2 | BR 1 | 6 | 0.53% | |
| | Loop | LS1 | LS 1 | LS 2 | | LS 2 | | LS2 | LS 2 | LS2 | LS 1 | 10 | 0.88% |
| | Mouth | | OP 1 | | OP 1 | | | OP 1 | | | DS 2 | 7 | 0.61% |
| | Hem | DS1 | | | | | | DS1 | TL1 | | OL | 10 | 0.88% |
| | Inseam | | | TL1 | SK1 | | | SK1 | | | | 2 | 0.17% |
| | Side Seam | | DS1 | | | OP2 | OP1 | | | | | 3 | 0.26% |
| | Waist | | | | | | | | SK1 | | | 1 | 0.08% |
| | Back | | TL1 | | TL2 | | | IS1 | | | | 5 | 0.44% |
| | Front | | | SK1 | | | | | | OP1 | | 4 | 0.35% |
| L/Chief sing | | | | | | | | | | | | | |
| Chief Controller | | | | | | | | | | | | | |

| B | B | E | Embroidery | IS | Incomplete stitch | N | Needle Mark | P | Puckering | S | Skip Stitch | TH | Thread Mistake | V | Visible Edge |
|---|---|----|----------------|----|-------------------|---|---------------|----|---------------|---|----------------|----|----------------|----|--------------|
| B | B | F | Fabric fault | I | Ink mark | N | Narrow Stitch | R | Run Of Stitch | S | Slanted Pocket | U | Uneven Stitch | W | Weave Zipper |
| B | R | G | Gathering | L | Level mistake | o | Oil Mark | R | Raw Edge | T | Twisted | UP | Uneven Point | W | M |
| D | D | HP | High law PKT | L | Loop Slanted | O | Open Stitch | RJ | Reject | T | Tension Tight | UI | Uneven Lob | WS | |
| D | T | H | High low waist | M | Missing Stich | O | Over Stitch | S | Shading | T | Tension Loose | U | Uneven width | W | Widith |

TABLE :6
BEATS FASHION LTD

Ends Line Inspection Report

Agent :ABA
Date :20 -03-2018
Buyer :JULES

Factory : BEATS
FASHION LTD
Item :711266
inspector : SHANAUR
PO/Art :325459
line :N-12

Style :SHORT PANT

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|-------------------------------------|-----------|------|------|------|------|------|------|-----|------|------|-------|---------|
| Total Received | 100 | 110 | 210 | 110 | 120 | 120 | 110 | 100 | 110 | 100 | 1090 | |
| | 100 | 210 | 320 | 423 | 532 | 654 | 765 | 880 | 990 | 1090 | | |
| Ok | 95 | 106 | 105 | 116 | 115 | 112 | 109 | 96 | 106 | 105 | | |
| | 95 | 201 | 307 | 423 | 513 | 634 | 723 | 842 | 943 | 1043 | | |
| Alter | 5 | 4 | 5 | 5 | 4 | 5 | 4 | 5 | 4 | 5 | 47 | 4.31% |
| | 5 | 10 | 14 | 16 | 19 | 26 | 32 | 38 | 42 | 47 | | |
| Alter Rectified | 5 | 4 | 5 | 5 | 4 | 5 | 4 | 5 | 4 | 5 | 47 | 4.37% |
| | 5 | 10 | 14 | 16 | 19 | 26 | 32 | 38 | 42 | 47 | | |
| Total Ok | 100 | 110 | 210 | 110 | 120 | 120 | 110 | 100 | 110 | 100 | | |
| | 100 | 210 | 320 | 423 | 532 | 654 | 765 | 880 | 990 | 1090 | | |
| L/Chief sing Chief Controller | Bar tack | BR 1 | | BR 1 | BR1 | BR 1 | BR1 | | BR 2 | BR 1 | 6 | 0.55% |
| | Loop | LS1 | LS 1 | LS 2 | | LS 2 | | LS2 | LS 2 | LS 1 | 11 | 1.00% |
| | Mouth | | OP 1 | | OP 1 | | OP 1 | | | DS 2 | 9 | 0.88% |
| | Hem | DS1 | | | | | DS1 | TL1 | | OL | 8 | 0.873% |
| | Inseam | | | TL1 | SK1 | | SK1 | | | | 1 | 0.09% |
| | Side Seam | | DS1 | | | OP2 | OP1 | | | | 3 | 0.27% |
| | Waist | | | | | | | | SK1 | | 2 | 0.18% |
| | Back | | TL1 | | TL2 | | IS1 | | | | 4 | 0.36% |
| | Front | | | SK1 | | | | | OP1 | | 3 | 0.27% |
| L/Chief sing | | | | | | | | | | | | |
| Chief | | | | | | | | | | | | |
| Controller | | | | | | | | | | | | |

| B | B | E | Embroidery | IS | Incomplete stitch | N | Needle Mark | P | Puckering | S | Skip Stitch | TH | Thread Mistake | V | Visible Edge |
|---|------------------|----|----------------|----|-------------------|---|---------------|----|---------------|---|----------------|----|----------------|----|--------------|
| B | Bubbling | F | Fabric fault | I | Ink mark | N | Narrow Stitch | R | Run Of Stitch | S | Slanted Pocket | U | Uneven Stitch | W | Weave Zipper |
| B | Bar tack missing | G | Gathering | L | Level mistake | o | Oil Mark | R | Raw Edge | T | Twisted | UP | Uneven Point | W | M |
| D | Damaged | HP | High law PKT | L | Loop Slanted | O | Open Stitch | RJ | Reject | T | Tension Tight | UI | Uneven Lob | WS | |
| D | Dirty | H | High low waist | M | Missing Stich | O | Over Stitch | S | Shading | T | Tension Loose | U | Uneven width | W | Widith |

Summary of Reports (FAIR TRADE GROUP) in sewing section.

| Date | Buyer | Inspected Qty | Defects | | | | | | | | | | | | | | | | | | | |
|-------------|----------|---------------|---------------|-------------|-------------|------------------|----------------|-------------|--------------|-----------|-----------|----------|---------------|-------------|-------------|-----------------|--------------|-------|----------------|--------|---------|--|
| | | | Broken stitch | Drop stitch | Needle hole | Bar tack missing | Improper shape | Join stitch | Loop slanted | Open seam | Puckering | Raw Edge | Tension loose | Skip stitch | Over stitch | Un-even lock in | Uncut thread | Pleat | Oil/Dirty Spot | Others | Rejects | |
| 21-03-2018 | Jules | 1653 | 3 | | 4 | 6 | | | 9 | 4 | | | 4 | 7 | - | 3 | 2 | | | | | |
| 19-03-18 | Jules | 1130 | 5 | | 6 | 6 | | | 10 | 3 | | | 2 | 5 | 4 | 5 | 5 | | | | | |
| 18-03-18 | J Jules | 1150 | 5 | | 7 | 9 | | | 12 | 2 | | | 4 | 4 | - | 4 | 3 | | | | | |
| 17-03-18 | Jules | 1130 | 9 | | 3 | 6 | | | 7 | 6 | | | 6 | 5 | 3 | 4 | 5 | | | | | |
| 15-03-18 | Jules | 1140 | 7 | | 2 | 9 | | | 9 | 4 | | | 4 | 4 | 4 | 2 | 5 | | | | | |
| 14-03-18 | Jules | 1260 | 5 | | 5 | 8 | | | 8 | 2 | | | - | 7 | 3 | 3 | 4 | | | | | |
| Grand Total | Total | 6630 | 29 | | 27 | 44 | | | 55 | 25 | | | 20 | 33 | 14 | | 31 | | | | | |
| | Defect % | 4.14 | 275 | | | | | | | | | | | | | | | | | | | |
| Defects % | | | 10.50 | | 9.81 | 15.54 | | | 19.92 | 9.09 | | | | 5.18 | 12 | 5.09 | 7.63 | 11.27 | | | | |

Here is the highest defects % is **19.92** that is Loop slanted

3.2.3 knitting data from finishing section :

Finishing section Table 1

| Order No: AO-17-1304 | | | | Style No: LEE | | | | Color: WHITE | | | |
|-----------------------------|-------|-------|-------|---------------|-------|-------|-------|----------------|-------|-------|-------|
| Buyer: H&M | | | | | | | | Date: 22-10-17 | | | |
| Defects Name | Hour | | | | | | | | | | Total |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | | 3 | 3 | | 2 | 1 | 1 | 3 | 3 | 2 | 18 |
| Button/snap/ Adjustable | 1 | | | | | | | 1 | | | 2 |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | 1 | 1 | 1 | | | | | 1 | 2 | | 6 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Raw edge | 1 | | | | | | | | 1 | | 2 |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | | | | | | | |
| Skip stitch | 1 | 1 | | | | 1 | 1 | 1 | | | 5 |
| Shading | | | | | | | | | | | |
| Strip not match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | | | | | | | | | | | |
| Un even | | | | | | | | | | | |
| Uncut thread | | | | | | | | | | | |
| Waviness | | | | | | | | | | | |

| | | | | | | | | | | | |
|-----------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------|
| Wrong SPI | | | | | | | | | | | |
| Label wrong placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Rocket | | | | | | | | | | | |
| Pleat | 1 | 2 | 1 | 2 | 2 | 1 | 2 | | | | 11 |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | | | | 1 | 1 |
| Dirty spot | 3 | 4 | 3 | 3 | 5 | 4 | 2 | | | 2 | 26 |
| Others | | | | | | | | | | | |
| Rejects | | | | 1 | | | | 2 | | | 3 |
| Pressing defects | | | | | | | | | | | |
| Loose tread | | | | | | | | | | | |
| Poor ironing shape | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| | | | | | | | | | | | |
| Total Inspected Qty | 120 | 140 | 120 | 120 | 150 | 120 | 130 | 100 | 120 | 130 | 1250 |
| Total OK Goods | 120 | 140 | 120 | 119 | 150 | 120 | 130 | 98 | 120 | 130 | 1247 |
| Total Defectives Qty | 8 | 11 | 8 | 6 | 9 | 7 | 6 | 8 | 6 | 5 | 74 |
| Rejects Qty | | | | 1 | | | | 2 | | | 3 |
| DHU% | | | | | | | | | | | 5.92% |
| QC pass% | | | | | | | | | | | 94.08% |

Finishing Table 2

| | | | | | | | | | | | |
|-----------------------------|-------|-------|-------|--------------------|-------|-------|-------|---------------|-------|-------|-------|
| Order No: 102534 | | | | Style No: 10196086 | | | | Color: BLACK | | | |
| Buyer: VEKO MODA | | | | | | | | Date: 13-1-18 | | | |
| Defects Name | Hour | | | | | | | | | | Total |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | | 1 | 1 | 1 | | | | | | | 3 |
| Button/snap/ Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | | | | | | | | |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Raw edge | | | | | | | | | | | |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | | | | | | | |
| Skip stitch | 2 | | | | 2 | | | | | | 4 |
| Shading | | | | | | | | | | | |
| Strip not match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | | | | | | | | | | | |
| Un even | | | | | | | | | | | |
| Uncut thread | | 1 | 2 | 2 | 2 | 2 | 2 | 3 | 3 | 3 | 20 |
| Waviness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |

| | | | | | | | | | | | |
|-----------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------|
| Label wrong placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Rocket | | | | | | | | | | | |
| Pleat | 1 | 1 | 1 | | | | | | | | 3 |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | | | | | |
| Dirty spot | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 3 | 3 | 2 | 15 |
| Others | | | | | | | | | | | |
| Rejects | 1 | | | | | | | | | | 1 |
| Pressing defects | | | | | | | | | | | |
| Loose tread | | | | | | | | | | | |
| Poor ironing shape | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| | | | | | | | | | | | |
| Total Inspected Qty | 100 | 100 | 100 | 120 | 120 | 100 | 100 | 220 | 220 | 220 | 1400 |
| Total OK Goods | 99 | 100 | 100 | 120 | 120 | 100 | 100 | 220 | 220 | 220 | 1399 |
| Total Defectives Qty | 5 | 4 | 5 | 4 | 5 | 3 | 3 | 6 | 6 | 5 | 46 |
| Rejects Qty | 1 | | | | | | | | | | |
| DHU% | | | | | | | | | | | 3.28% |
| QC pass% | | | | | | | | | | | 96.72% |

Finishing Table 3

| Order No: 191448/AO-18-52 | Style No: RONNY | | | | | Color: LIGHT GREY | | | | | |
|-----------------------------|-----------------|-------|-------|-------|------------------|-------------------|-------|-------|-------|-------|-------|
| Buyer: H&M | | | | | Date: 11-03-2018 | | | | | | |
| Defects Name | Hour | | | | | | | | | | |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | Total |
| Broken stitch | | | | | | | | | | | |
| Button/snap/ Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut damage | | | | | | 2 | 1 | | | | 3 |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | 1 | | | | | | | 1 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Raw edge | | | | | | | | | | | |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | | | | | | | |
| Skip stitch | | | | 1 | | | | | | | 1 |
| Shading | | | | | | | | | | | |
| Strip not match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | | | | | | | | | | | |
| Un even | | | | | | | | | | | |
| Uncut thread | | | 1 | | | | | | | | 1 |

| | | | | | | | | | | | |
|-----------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------|
| Waviness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong placement | | | | | | | | | | | |
| Yarn contamination | 1 | 1 | | | | | 1 | | | 1 | 4 |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Rocket | | | | | | | | | | | |
| Pleat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | | | | | |
| Dirty spot | 1 | 1 | 2 | | | 3 | 1 | 1 | | 2 | 11 |
| Others | | | | | | | | | | | |
| Rejects | | | | 1 | | 1 | | | | | 2 |
| Pressing defects | | | | | | | | | | | |
| Loose tread | | | | | | | | | | | |
| Poor ironing shape | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| | | | | | | | | | | | |
| Total Inspected Qty | 240 | 210 | 180 | 150 | 140 | 220 | 200 | 220 | 170 | 260 | 1990 |
| Total OK Goods | 240 | 210 | 180 | 149 | 140 | 219 | 200 | 220 | 170 | 260 | 1988 |
| Total Defectives Qty | 2 | 2 | 3 | 3 | 0 | 7 | 2 | 1 | 0 | 3 | 23 |
| Rejects Qty | | | | 1 | | 1 | | | | | 2 |
| DHU% | | | | | | | | | | | 1.15% |
| QC pass% | | | | | | | | | | | 98.85% |

Finishing Table 4

| | | | | | | | | | | | |
|-----------------------------|-------|-------|-------|----------------|-------|-------|------------------|--------------------|-------|-------|-------|
| Order No: 291448 | | | | Style No: RONY | | | | Color: LIGHT GRREY | | | |
| Buyer: H&M | | | | | | | Date: 12-03-2018 | | | | |
| Defects Name | Hour | | | | | | | | | | |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | Total |
| Broken stitch | | 1 | | 1 | 1 | | | 1 | 1 | 2 | 7 |
| Button/snap/ Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | | | | | | | | |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Raw edge | | | | | | | | | | | |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | | | | | | | |
| Skip stitch | | | | | | 1 | | | | | 1 |
| Shading | | | | | | | | | | | |
| Strip not match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | | | | | | | | | | | |
| Un even | | | | | | | | | | | |
| Uncut thread | | | | | | | | | | | |
| Waviness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong | | | | | | | | | | | |

| | | | | | | | | | | | |
|----------------------|-----|-----|-----|-----|-----|-----|----|-----|-----|-----|--------|
| placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Rocket | | | | | | | | | | | |
| Pleat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | 1 | 2 | 1 | 2 | 6 |
| Dirty spot | 2 | 2 | 1 | 2 | 2 | | | | | | 9 |
| Others | | | | | | | | | | | |
| Rejects | | | | | | | | | | | |
| Pressing defects | | | | | | | | | | | |
| Loose tread | | | | | | | | | | | |
| Poor ironing shape | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| | | | | | | | | | | | |
| Total Inspected Qty | 180 | 180 | 150 | 160 | 150 | 100 | 90 | 180 | 170 | 150 | 1510 |
| Total OK Goods | 180 | 180 | 150 | 160 | 150 | 100 | 90 | 180 | 170 | 150 | 1510 |
| Total Defectives Qty | 2 | 3 | 1 | 3 | 3 | 1 | 1 | 3 | 2 | 4 | 23 |
| Rejects Qty | | | | | | | | | | | |
| DHU% | | | | | | | | | | | 1.52% |
| QC pass% | | | | | | | | | | | 98.48% |

Finishing Table 5

| | | | | | | | | | | | |
|-----------------------------|-------|-------|---------------|-------|-------|----------------|--------------|-------|-------|-------|-------|
| Order No: 289774/ AO-18-233 | | | Style No: BOB | | | | Color: BLACK | | | | |
| Buyer: H&M | | | | | | Date: 13-03-18 | | | | | |
| Defects Name | Hour | | | | | | | | | | |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | Total |
| Broken stitch | | | | | 1 | 1 | | | | 1 | 3 |
| Button/snap/ Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut damage | 2 | | | | 1 | | | | | | 3 |
| Improper tuck | | | 1 | | | | | | | | 1 |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | | | | | | | 1 | 1 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Raw edge | | | | | | | | | | | |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | | | | | | | |
| Skip stitch | | | | 1 | | | | | | | 1 |
| Shading | | | | | | | | | | | |
| Strip not match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | | | | | | | | | | | |
| Un even | | | | | | | | | | | |
| Uncut thread | | | | | | | | | | | |
| Waviness | | | | 2 | | | 1 | 2 | | | 5 |
| Wrong SPI | | | | | | | | | | | |
| Label wrong | | | | | | | | | | | |

| | | | | | | | | | | | |
|----------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------|
| placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Rocket | | | | | | | | | | | |
| Pleat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | 2 | 1 | 1 | | 2 | 2 | | 2 | 2 | 12 |
| Dirty spot | | 1 | | | | | | | | | 1 |
| Others | | 1 | | 1 | | | | | | | 2 |
| Rejects | | | | | | | | 1 | | | 1 |
| Pressing defects | | | | | | | | | | | |
| Loose tread | | | | | | | | | | | |
| Poor ironing shape | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| | | | | | | | | | | | |
| Total Inspected Qty | 154 | 170 | 150 | 170 | 165 | 190 | 210 | 220 | 250 | 350 | 2029 |
| Total OK Goods | 154 | 170 | 150 | 170 | 165 | 190 | 210 | 219 | 250 | 350 | 2028 |
| Total Defectives Qty | 2 | 4 | 2 | 5 | 2 | 3 | 3 | 3 | 2 | 4 | 30 |
| Rejects Qty | | | | | | | | 1 | | | 1 |
| DHU% | | | | | | | | | | | 1.48% |
| QC pass% | | | | | | | | | | | 98.52% |

Finishing Table 6

| Order No: 274795AONO-17-1806 | | | | Style No: MOA | | | | Color: WHITE | | | |
|------------------------------|-------|-------|-------|---------------|-------|-------|-------|----------------|-------|-------|-------|
| Buyer: H&M | | | | | | | | Date: 03-03-18 | | | |
| Defects Name | Hour | | | | | | | | | | Total |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | 2 | | 1 | 3 | 1 | 1 | | 1 | | 1 | 10 |
| Button/snap/ Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | 5 | 1 | 1 | | | 1 | 1 | 2 | | 2 | 13 |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut damage | | | 1 | | | | | | | | 1 |
| Improper tuck | 1 | | | 1 | | | | | | | 2 |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | 2 | | | | 1 | | | | | 3 |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | 2 | 1 | | | | | | 3 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Raw edge | | | 1 | | | | | | | | 1 |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | | | | | | | |
| Skip stitch | 1 | 2 | 2 | 2 | 3 | 1 | 1 | 1 | | 1 | 14 |
| Shading | | | | | | | | | | | |
| Strip not match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | 1 | 1 | 2 |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | | | | | | | | | | | |
| Un even | | | | | | | | | | | |
| Uncut thread | | | | | | | | | | | |
| Waviness | | | | | | | | | | | |

| | | | | | | | | | | | |
|-----------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------|
| Wrong SPI | | | | | | | | | | | |
| Label wrong placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Rocket | | | | | | | | | | | |
| Pleat | | | 1 | 2 | | 1 | 1 | | 1 | 1 | 7 |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | | | 2 | 2 | 4 |
| Dirty spot | 13 | 25 | 27 | 29 | 26 | 19 | 15 | 17 | 15 | 14 | 200 |
| Others | | | | | | | | | | | |
| Rejects | | 2 | 1 | 3 | 2 | | | 1 | | 1 | 10 |
| Pressing defects | | | | | | | | | | | |
| Loose tread | | | | | | | | | | | |
| Poor ironing shape | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| | | | | | | | | | | | |
| Total Inspected Qty | 300 | 350 | 390 | 450 | 390 | 390 | 300 | 430 | 380 | 390 | 6170 |
| Total OK Goods | 300 | 348 | 389 | 447 | 388 | 390 | 300 | 429 | 380 | 390 | 6160 |
| Total Defectives Qty | 22 | 32 | 35 | 42 | 33 | 24 | 18 | 22 | 23 | 25 | 276 |
| Rejects Qty | | 2 | 1 | 3 | 2 | | | 1 | | 1 | 10 |
| DHU% | | | | | | | | | | | 4.47% |
| QC pass% | | | | | | | | | | | 95.53% |

Finishing Table 7

| | | | | | | | | | | | |
|-----------------------------|-------|-------|-------|----------------|-------|-------|-------|------------------|-------|-------|-------|
| Order No: 217007 | | | | Style No: LIMA | | | | Color: PINK | | | |
| Buyer: H&M | | | | | | | | Date: 22-10-2017 | | | |
| Defects Name | Hour | | | | | | | | | | Total |
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | | 2 | | 2 | | | | | | | 4 |
| Button/snap/ Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | 1 | | | | | | | | 1 |
| Cut damage | | 1 | | | | | | | | | 1 |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | 1 | | | | | | | 1 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Raw edge | | 2 | | 1 | | | | | | | 3 |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | 2 | | | | | | 2 |
| Skip stitch | | | | | | | | | | | |
| Shading | | | | | | | | | | | |
| Strip not match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up down | | | | | | | | | | | |
| Un even | | | | | | | | | | | |
| Uncut thread | 3 | | 3 | | | | | | | | 6 |
| Waviness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong | | | | | | | | | | | |

| | | | | | | | | | | | |
|----------------------|----|-----|-----|-----|----|--|--|--|--|--|--------|
| placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Rocket | | | | | | | | | | | |
| Pleat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | | 2 | 2 | 1 | | | | | | 5 |
| Dirty spot | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| Rejects | | | | 1 | | | | | | | 1 |
| Pressing defects | | | | | | | | | | | |
| Loose tread | | | | | | | | | | | |
| Poor ironing shape | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| | | | | | | | | | | | |
| Total Inspected Qty | 65 | 100 | 100 | 105 | 85 | | | | | | 455 |
| Total OK Goods | 65 | 100 | 100 | 104 | 85 | | | | | | 454 |
| Total Defectives Qty | 3 | 5 | 6 | 7 | 3 | | | | | | 24 |
| Rejects Qty | | | | 1 | | | | | | | 1 |
| DHU% | | | | | | | | | | | 5.27% |
| QC pass% | | | | | | | | | | | 96.73% |

Summary of Reports (Aman Tex Ltd.) in finishing section

| Date | Buyer | Inspected Qty | Defects | | | | | | | | | | | | | | | | | |
|------------|-----------|---------------|---------------|--------|-----------|----------|-------------|-------|----------|------------|--------------|------------|--------------------|----------|-------------|----------|-------------|---------|---------|--------|
| | | | Broken stitch | Button | Open seam | Raw edge | Skip stitch | pleat | Oil spot | Dirty spot | Uncut thread | Cut damage | Yarn contamination | waviness | Join stitch | Twisting | Needle hole | Slanted | Rejects | Others |
| | | | 22-10-17 | H&M | 1250 | 18 | 2 | 6 | 2 | 5 | 11 | 1 | 26 | 0 | 0 | 0 | 0 | 0 | 0 | 0 |
| 3-1-18 | VEKO MODA | 1400 | 3 | 0 | 0 | 0 | 4 | 3 | 0 | 15 | 20 | 0 | 0 | 0 | 0 | 0 | 0 | 1 | 0 | |
| 11-03-18 | H&M | 1990 | | 0 | 1 | 0 | 1 | 0 | 0 | 11 | 1 | 3 | 4 | 0 | 0 | 0 | 0 | 2 | 0 | |
| 12-03-18 | H&M | 1510 | 7 | 0 | 0 | 0 | 1 | 0 | 6 | 9 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | |
| 13-03-18 | H&M | 2029 | 3 | 0 | 1 | 0 | 1 | 0 | 12 | 1 | 0 | 3 | 0 | 5 | 0 | 0 | 0 | 1 | 2 | |
| 3-03-18 | H&M | 6170 | 10 | 0 | 3 | 1 | 14 | 7 | 4 | 200 | 0 | 1 | 0 | 0 | 3 | 2 | 0 | 0 | 10 | |
| 22-10-2017 | H&M | 455 | 4 | 0 | 1 | 3 | 0 | 0 | 5 | 0 | 6 | 1 | 0 | 0 | 0 | 0 | 1 | 2 | 1 | |
| Total | 14804 | | 45 | 2 | 12 | 6 | 26 | 21 | 28 | 262 | 27 | 8 | 4 | 5 | 3 | 2 | 1 | 2 | 18 | |
| | | | 474 (3.20%) | | | | | | | | | | | | | | | | | |
| | | Defect % | 9.49 | 0.42 | 2.53 | 1.26 | 5.48 | 4.43 | 5.90 | 55.27 | 5.69 | 1.68 | 0.84 | 1.05 | 0.63 | 0.42 | 0.21 | 0.42 | 3.79 | 0.42 |

Here is the highest defects % **55.27** dirty spot.

3.2.4 Woven data from finishing section :

TABLE :1
BEATS FASHION LTD.

Agent :ABA
Date :14-03-2018
Buyer :TRENT

Ends Line Inspection Report

Factory : BEATS
FASHION LTD
Item :126222
Inspector : LAILY
PO/Art :325459
line :N-12

Style :SHORT

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|------------------|----------|-----------|-----------|-----------|----------|----------|-----------|----------|------|------|-------|---------|
| Total Received | 643 | 463 | 340 | 440 | 440 | 450 | 480 | 450 | 470 | 433 | 4465 | 9.5% |
| | 643 | 1103 | 1443 | 1883 | 2767 | 3112 | 3562 | 3562 | 4032 | 4465 | | |
| Ok | 600 | 451 | 320 | 395 | 403 | 421 | 423 | 400 | 420 | 400 | 4070 | |
| | 600 | 1050 | 1350 | 1750 | 2150 | 2550 | 2850 | 3250 | 3670 | 4070 | | |
| Alter | 43 | 40 | 40 | 40 | 44 | 45 | 50 | 50 | 50 | 33 | 425 | |
| | 43 | 83 | 123 | 197 | 240 | 287 | 292 | 342 | 392 | 425 | | |
| Alter Rectified | 20 | 10 | 20 | 20 | 16 | 18 | 30 | 21 | 30 | 20 | 220 | |
| | 20 | 30 | 50 | 80 | 120 | 150 | 160 | 170 | 200 | 220 | | |
| Total Ok | 620 | 451 | 320 | 395 | 403 | 421 | 423 | 400 | 450 | 420 | 4290 | |
| | 620 | 1050 | 1350 | 1750 | 2150 | 2550 | 2850 | 3250 | 3870 | 4290 | | |
| Waist | B-10 | B-10 | SK-5/D3 | B-5/D-2 | B-4/D2 | B-5/D2 | D-4/SK-10 | B-10 | SK-5 | | | |
| Front part | SK-5/B-5 | BR-6/D-3 | BR-5/D-2 | BR-5/D-2 | SK-5/SK- | BR-7/B-4 | BR-6/B-3 | D-6/BK-5 | SK-5 | B-10 | | |
| Side seam | O5P-3 | BR-3/SK-5 | SK-5/OP-2 | OP-3/SK-5 | SK-5 | SK-4 | OP-7 | BR-5 | B-10 | OP-3 | | |
| In seam | | SK-3 | | SK-6 | SK-4 | SK-6 | | | | SK-9 | | |
| Back part | B-10 | SK-5 | B-10 | SK-5 | B-20 | BR-5 | B-10 | | B-10 | B-10 | | |
| Bottom | B-10 | B-5 | B-10 | D-3 | B-6 | B-10 | SK-5 | | B-10 | SK-5 | | |
| L/Chief sing | | | | | | | | | | | | |
| Chief Controller | | | | | | | | | | | | |

| | | | | | | | | | | | | | | | |
|---|------------------|----|----------------|----|-------------------|---|---------------|----|---------------|---|----------------|----|----------------|----|--------------|
| B | Brocken stitch | E | Embroidery | IS | Incomplete stitch | N | Needle Mark | P | Puckering | S | Skip Stitch | TH | Thread Mistake | V | Visible Edge |
| B | Bubbling | F | Fabric fault | I | Ink mark | N | Narrow Stitch | R | Run Of Stitch | S | Slanted Pocket | U | Uneven Stitch | W | Weave Zipper |
| B | Bar tack missing | G | Gathering | L | Level mistake | o | Oil Mark | R | Raw Edge | T | Twisted | UP | Uneven Point | W | M |
| D | Damag e | HP | High law PKT | L | Loop Slanted | O | Open Stitch | RJ | Reject | T | Tension Tight | UI | Uneven Lob | WS | |
| D | Dirty | H | High low waist | M | Missing Stich | O | Over Stitch | S | Shading | T | Tension Loose | U | Uneven width | DS | |

TABLE :2
BEATS FASHION LTD.

Ends Line Inspection Report

Agent :ABA
Date :15-03-2018
Buyer :TRENT

Factory : BEATS
FASHION LTD
Inspector : LAILY
PO/Ar: 325459
line :N-12

Style :SHORT

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|------------------|----------|-----------|-----------|-----------|----------|----------|-----------|----------|------|------|-------|---------|
| Total Received | 640 | 710 | 665 | 550 | 260 | 560 | 541 | 556 | 550 | 442 | 5474 | 9.59% |
| | 640 | 1350 | 2028 | 2579 | 2670 | 3245 | 3876 | 4482 | 5032 | 5474 | | |
| Ok | 570 | 540 | 6403 | 500 | 200 | 600 | 500 | 520 | 510 | 400 | 4940 | |
| | 570 | 1210 | 1880 | 2310 | 1510 | 3010 | 4030 | 4030 | 4540 | 4940 | | |
| Alter | 70 | 70 | 65 | 50 | 60 | 50 | 55 | 65 | 40 | 42 | 525 | |
| | 70 | 140 | 250 | 332 | 432 | 543 | 654 | 483 | 583 | 525 | | |
| Alter Rectified | 20 | 30 | 30 | 20 | 20 | 30 | 40 | 30 | 30 | 30 | 290 | |
| | 20 | 50 | 80 | 110 | 130 | 140 | 170 | 190 | 260 | 290 | | |
| Total Ok | 590 | 710 | 665 | 550 | 260 | 560 | 541 | 556 | 540 | 430 | 5230 | |
| | 590 | 1350 | 2028 | 2579 | 2670 | 3245 | 3876 | 4482 | 480 | 5230 | | |
| Waist | B-10 | B-10 | SK-5/D3 | B-5/D-2 | B-4/D2 | B-5/D2 | D-4/SK-10 | B-10 | SK-5 | | | |
| Front part | SK-5/B-5 | BR-6/D-3 | BR-5/D-2 | BR-5/D-2 | SK-5/SK- | BR-7/B-4 | BR-6/B-3 | D-6/BK-5 | SK-5 | B-10 | | |
| Side seam | O5P-3 | BR-3/SK-5 | SK-5/OP-2 | OP-3/SK-5 | SK-5 | SK-4 | OP-7 | BR-5 | B-10 | OP-3 | | |
| In seam | | SK-3 | | SK-6 | SK-4 | SK-6 | | | | SK-9 | | |
| Back part | B-10 | SK-5 | B-10 | SK-5 | B-20 | BR-5 | B-10 | | B-10 | B-10 | | |
| Bottom | B-10 | B-5 | B-10 | D-3 | B-6 | B-10 | SK-5 | | B-10 | SK-5 | | |
| L/Chief sing | | | | | | | | | | | | |
| Chief Controller | | | | | | | | | | | | |

| B | B | E | Embroidery | IS | Incomplete stitch | N | Needle Mark | P | Puckering | S | Skip Stitch | TH | Thread Mistake | V | Visible Edge |
|---|------------------|----|----------------|----|-------------------|---|---------------|----|---------------|---|----------------|----|----------------|----|--------------|
| B | Bubbling | F | Fabric fault | I | Ink mark | N | Narrow Stitch | R | Run Of Stitch | S | Slanted Pocket | U | Uneven Stitch | W | Weave Zipper |
| B | Bar tack missing | G | Gathering | L | Level mistake | o | Oil Mark | R | Raw Edge | T | Twisted | UP | Uneven Point | W | M |
| D | Damag e | HP | High law PKT | L | Loop Slanted | O | Open Stúch | RJ | Reject | T | Tension Tight | UI | Uneven Lob | WS | |
| D | Dirty | H | High low waist | M | Missing Stich | O | Over Stich | S | Shading | T | Tension Loose | U | Uneven width | DS | |

TABLE :3
BEATS FASHION LTD

Ends Line Inspection Report

Agent :ABA
Date :17-03-2018
Buyer :TRENT

Factory : BEATS
FASHION LTD
Item :126222
Inspector : LAILY
PO/Art :325459
line :N-12

Style :SHORT

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|------------------|----------|-----------|-----------|-----------|----------|----------|-----------|----------|------|------|-------|---------|
| Total Received | 345 | 400 | 470 | 540 | 490 | 545 | 544 | 510 | 554 | 210 | 4644 | 9.56% |
| | 345 | 776 | 1215 | 1750 | 2346 | 3125 | 3331 | 3850 | 4404 | 4644 | | |
| Ok | 300 | 360 | 420 | 532 | 532 | 653 | 412 | 470 | 500 | 200 | 4200 | |
| | 300 | 650 | 1080 | 1680 | 2146 | 2890 | 3421 | 3500 | 4000 | 4200 | | |
| Alter | 45 | 40 | 50 | 40 | 54 | 45 | 50 | 46 | 54 | 40 | 444 | |
| | 45 | 81 | 135 | 175 | 231 | 367 | 345 | 345 | 404 | 444 | | |
| Alter Rectified | 20 | 20 | 20 | 20 | 34 | 25 | 30 | 30 | 30 | 20 | 240 | |
| | 20 | 40 | 60 | 80 | 130 | 157 | 180 | 190 | 220 | 240 | | |
| Total Ok | 320 | 400 | 470 | 540 | 490 | 545 | 544 | 510 | 530 | 220 | 4440 | |
| | 320 | 776 | 1215 | 1750 | 2346 | 3125 | 3331 | 3850 | 4220 | 4440 | | |
| Waist | B-10 | B-10 | SK-5/D3 | B-5/D-2 | B-4/D2 | B-5/D2 | D-4/SK-10 | B-10 | SK-5 | | | |
| Front part | SK-5/B-5 | BR-6/D-3 | BR-5/D-2 | BR-5/D-2 | SK-5/SK- | BR-7/B-4 | BR-6/B-3 | D-6/BK-5 | SK-5 | B-10 | | |
| Side seam | O5P-3 | BR-3/SK-5 | SK-5/OP-2 | OP-3/SK-5 | SK-5 | SK-4 | OP-7 | BR-5 | B-10 | OP-3 | | |
| In seam | | SK-3 | | SK-6 | SK-4 | SK-6 | | | | SK-9 | | |
| Back part | B-10 | SK-5 | B-10 | SK-5 | B-20 | BR-5 | B-10 | | B-10 | B-10 | | |
| Bottom | B-10 | B-5 | B-10 | D-3 | B-6 | B-10 | SK-5 | | B-10 | SK-5 | | |
| L/Chief sing | | | | | | | | | | | | |
| Chief Controller | | | | | | | | | | | | |

| B | B | E | IS | N | P | S | TH | V | W |
|------------------|--------------|-------------------|---------------|---------------|----------------|----------------|--------------|----|---|
| Brocken stitch | Embroidery | Incomplete stitch | Needle Mark | Puckering | Skip Stitch | Thread Mistake | Visible Edge | | |
| Bubbling | Fabric fault | Ink mark | Narrow Stitch | Run Of Stitch | Slanted Pocket | Uneven Stitch | Weave Zipper | | |
| Bar tack missing | Gathering | Level mistake | Oil Mark | Raw Edge | Twisted | Uneven Point | WM | | |
| Damag e | HP | High law PKT | LS | Loop Slanted | Open Stitch | Reject | Reject | WS | |
| Dirty | HW | High low waist | M | Missing Stich | Over Stich | Shading | Shading | DS | |

TABLE :4
BEATS FASHION LTD

Ends Line Inspection Report

Agent :ABA
Date :18-03-2018
Buyer : TRENT

Factory : BEATS
FASHION LTD
Item :126222
Inspector : LAILY
PO/Art :325459

line :N-12

Style :SHORT

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|------------------|----------|-----------|-----------|-----------|----------|----------|-----------|----------|------|------|-------|---------|
| Total Received | 336 | 445 | 460 | 296 | 245 | 210 | 435 | 330 | 116 | 435 | 3288 | 12.41% |
| | 366 | 840 | 1280 | 1907 | 2314 | 2894 | 2345 | 2430 | 2853 | 3288 | | |
| Ok | 300 | 400 | 300 | 345 | 432 | 556 | 345 | 300 | 100 | 400 | 2930 | |
| | 300 | 700 | 1164 | 1567 | 1843 | 2135 | 2130 | 2430 | 2530 | 2930 | | |
| Alter | 66 | 55 | 60 | 46 | 45 | 30 | 35 | 30 | 30 | 35 | 418 | |
| | 66 | 120 | 181 | 145 | 167 | 190 | 223 | 280 | 383 | 418 | | |
| Alter Rectified | 20 | 30 | 30 | 20 | 30 | 20 | 34 | 16 | 35 | 35 | 210 | |
| | 20 | 50 | 80 | 120 | 100 | 150 | 160 | 170 | 190 | 210 | | |
| Total Ok | 320 | 430 | 460 | 296 | 245 | 210 | 435 | 330 | 110 | 420 | 3140 | |
| | 320 | 750 | 1280 | 1907 | 2314 | 2894 | 2345 | 2430 | 2720 | 3140 | | |
| Waist | B-10 | B-10 | SK-5/D3 | B-5/D-2 | B-4/D2 | B-5/D2 | D-4/SK-10 | B-10 | SK-5 | | | |
| Front part | SK-5/B-5 | BR-6/D-3 | BR-5/D-2 | BR-5/D-2 | SK-5/SK- | BR-7/B-4 | BR-6/B-3 | D-6/BK-5 | SK-5 | B-10 | | |
| Side seam | O5P-3 | BR-3/SK-5 | SK-5/OP-2 | OP-3/SK-5 | SK-5 | SK-4 | OP-7 | BR-5 | B-10 | OP-3 | | |
| In seam | | SK-3 | | SK-6 | SK-4 | SK-6 | | | | SK-9 | | |
| Back part | B-10 | SK-5 | B-10 | SK-5 | B-20 | BR-5 | B-10 | | B-10 | B-10 | | |
| Bottom | B-10 | B-5 | B-10 | D-3 | B-6 | B-10 | SK-5 | | B-10 | SK-5 | | |
| L/Chief sing | | | | | | | | | | | | |
| Chief Controller | | | | | | | | | | | | |

| B | B | E | IS | N | P | S | TH | V | Visibl | | | | | | |
|---|------------------|----|----------------|----|--------------------|---|----------------|----|---------------|---|-----------------|----|----------------|-----|----------------|
| B | Brocke n stitch | E | Embroide ry | IS | Incomple te stitch | N | Needl e Mark | P | Puckeri ng | S | Skip Stitch | TH | Thread Mistake | V | Visibl e Edge |
| B | Bubbl ing | F | Fabric fault | I | Ink mark | N | Narro w Stitch | R | Run Of Stitch | S | Slante d Pocket | U | Uneven Stitch | W | Weav eb Zipper |
| B | Bar tack missing | G | Gathering | L | Level mistake | o | Oil Mark | R | Raw Edge | T | Twiste d | UP | Uneven Point | W | M |
| D | Damag e | HP | High law PKT | L | Loop Slanted | O | Open Stitch | RJ | Reject | T | Tensio n Tight | UI | Uneven Lob | WS | |
| D | Dirty | H | High low waist | M | Missing Stich | O | Over Stitch | S | Shading | T | Tensio n Loose | U | Uneven width | Wid | ith |

TABLE :5
BEATS FASHION LTD

Ends Line Inspection Report

Agent : ABA
Date : 19-03-2018
Buyer : TRENT
Style : SHORT

Factory : BEATS FASHION LTD
Item : 126222
Inspector : LAILY
PO/Art : 325459
line : N-12

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|------------------|----------|-----------|-----------|-----------|----------|----------|-----------|----------|------|------|-------|---------|
| Total Received | 334 | 590 | 550 | 650 | | | 58 | 171 | 125 | 175 | 2664 | 9.53% |
| | 335 | 925 | 1475 | 2125 | | | 2183 | 2489 | 2489 | 2664 | | |
| Ok | 300 | 550 | 500 | 600 | | | 50 | 150 | 100 | 150 | 2400 | |
| | 300 | 850 | 500 | 1350 | | | 2000 | 2150 | 2250 | 2400 | | |
| Alter | 35 | 40 | 50 | 50 | | | 8 | 21 | 25 | 25 | 254 | |
| | 35 | 75 | 125 | 175 | | | 183 | 204 | 229 | 254 | | |
| Alter Rectified | 10 | 20 | 30 | 30 | | | 10 | 10 | 10 | 10 | 130 | |
| | 10 | 30 | 60 | 90 | | | 2000 | 2150 | 2250 | 2400 | | |
| Total Ok | 210 | 590 | 550 | 650 | | | 58 | 171 | 110 | 160 | 2530 | |
| | 310 | 925 | 1475 | 2125 | | | 2183 | 2489 | 2370 | 2630 | | |
| Waist | B-10 | B-10 | SK-5/D3 | B-5/D-2 | B-4/D2 | B-5/D2 | D-4/SK-10 | B-10 | SK-5 | | | |
| Front part | SK-5/B-5 | BR-6/D-3 | BR-5/D-2 | BR-5/D-2 | SK-5/SK- | BR-7/B-4 | BR-6/B-3 | D-6/BK-5 | SK-5 | B-10 | | |
| Side seam | O5P-3 | BR-3/SK-5 | SK-5/OP-2 | OP-3/SK-5 | SK-5 | SK-4 | OP-7 | BR-5 | B-10 | OP-3 | | |
| In seam | | SK-3 | | SK-6 | SK-4 | SK-6 | | | | SK-9 | | |
| Back part | B-10 | SK-5 | B-10 | SK-5 | B-20 | BR-5 | B-10 | | B-10 | B-10 | | |
| Bottom | B-10 | B-5 | B-10 | D-3 | B-6 | B-10 | SK-5 | | B-10 | SK-5 | | |
| L/Chief sing | | | | | | | | | | | | |
| Chief Controller | | | | | | | | | | | | |

| B | B | E | IS | N | P | S | SK | TH | V | W | WS | DS |
|------------------|----|----------------|-------------------|---------------|--------|---------------|----------------|---------------|--------|--------------|----|----|
| Brocken stitch | | Embroidery | Incomplete stitch | Needle Mark | Pucker | Skip Stitch | Thread Mistake | Visible Edge | | | | |
| Bubbling | F | Fabric fault | Ink mark | Narrow Stitch | R | Run Of Stitch | Slanted Pocket | Uneven Stitch | W | Weave Zipper | | |
| Bar tack missing | G | Gathering | Level mistake | Oil Mark | RE | Raw Edge | Twisted | Uneven Point | WM | | | |
| Damag e | HP | High law PKT | Loop Slanted | Open Stitch | RJ | Reject | Tension Tight | Uneven Lob | WS | | | |
| Dirty | HW | High low waist | Missing Stich | Over Stich | S | Shading | Tension Loose | Uneven width | Widith | DS | | |

TABLE :6
BEATS FASHION LTD

Ends Line Inspection Report

Agent :ABA
Date :21-03-2018
Buyer :MS MODE

Factory : BEATS
FASHION LTD
Item :126222
Inspector : LAILY
PO/Art :325459
line :N-12

Style :Mens shirts

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|------------------|----------|-----------|-----------|-----------|----------|----------|-----------|----------|------|------|-------|---------|
| Total Received | 320 | 320 | 350 | 380 | 375 | 431 | 546 | 330 | 235 | 286 | 3663 | 8.24% |
| | 320 | 610 | 990 | 1370 | 2176 | 2722 | 3052 | 3181 | 3673 | 3673 | | |
| Ok | 300 | 300 | 320 | 350 | 400 | 500 | 300 | 200 | 200 | 350 | 3370 | |
| | 300 | 600 | 920 | 1350 | 200 | 2711 | 2520 | 2800 | 3020 | 3370 | | |
| Alter | 20 | 20 | 30 | 30 | 25 | 31 | 46 | 30 | 30 | 35 | 303 | |
| | 20 | 40 | 50 | 70 | 90 | 110 | 130 | 150 | 140 | 160 | | |
| Alter Rectified | 10 | 10 | 20 | 10 | 20 | 20 | 30 | 20 | 10 | 20 | 160 | |
| | 10 | 20 | 40 | 50 | 70 | 80 | 90 | 110 | 140 | 160 | | |
| Total Ok | 310 | 320 | 350 | 380 | 375 | 431 | 546 | 330 | 210 | 370 | 3540 | |
| | 310 | 610 | 990 | 1370 | 2176 | 2722 | 3052 | 3181 | 3170 | 3540 | | |
| Waist | B-10 | B-10 | SK-5/D3 | B-5/D-2 | B-4/D2 | B-5/D2 | D-4/SK-10 | B-10 | SK-5 | | | |
| Front part | SK-5/B-5 | BR-6/D-3 | BR-5/D-2 | BR-5/D-2 | SK-5/SK- | BR-7/B-4 | BR-6/B-3 | D-6/BK-5 | SK-5 | B-10 | | |
| Side seam | O5P-3 | BR-3/SK-5 | SK-5/OP-2 | OP-3/SK-5 | SK-5 | SK-4 | OP-7 | BR-5 | B-10 | OP-3 | | |
| In seam | | SK-3 | | SK-6 | SK-4 | SK-6 | | | | SK-9 | | |
| Back part | B-10 | SK-5 | B-10 | SK-5 | B-20 | BR-5 | B-10 | | B-10 | B-10 | | |
| Bottom | B-10 | B-5 | B-10 | D-3 | B-6 | B-10 | SK-5 | | B-10 | SK-5 | | |
| L/Chief sing | | | | | | | | | | | | |
| Chief Controller | | | | | | | | | | | | |

| B | B | E | IS | N | P | S | TH | V | Visibl | | | | | | |
|---|------------------|----|----------------|----|--------------------|---|----------------|----|---------------|---|-----------------|----|---------------------|----|----------------|
| B | Brocke n stitch | E | Embroide ry | IS | Incomple te stitch | N | Needl e Mark | P | Puckeri ng | S | Skip Stitch | TH | Thread Mistake | V | Visibl e Edge |
| B | Bubbl ing | F | Fabric fault | I | Ink mark | N | Narro w Stitch | R | Run Of Stitch | S | Slante d Pocket | U | Uneven Stitch | W | Weav eb Zipper |
| B | Bar tack missing | G | Gathering | L | Level mistake | o | Oil Mark | R | Raw Edge | T | Twiste d | UP | Uneven Point | W | M |
| D | Damag e | HP | High law PKT | L | Loop Slanted | O | Open Stitch | RJ | Reject | T | Tensio n Tight | UI | Uneven Lob | WS | |
| D | Dirty | H | High low waist | M | Missing Stich | O | Over Stich | S | Shading | T | Tensio n Loose | U | Uneven widthWid ith | DS | |

Summary of Reports (FAIR TRAD GROUP) in Finishing section

| Date | Buyer | Inspected Qty | Defects | | | | | | | | | | | | | | | | |
|----------|-------------|---------------|---------------|--------|-----------|----------|-------------|-------|----------|------------|--------------|------------|------------------|--------|-------------|----------|-------------|---------|---------|
| | | | Broken stitch | Button | Open seam | Raw edge | Skip stitch | pleat | Oil spot | Dirty spot | Uncut thread | Cut damage | BAR TACK MISSING | Damage | Join stitch | Twisting | Needle hole | Slanted | Rejects |
| 21-03-18 | OKAIDI | 3554 | 63 | | | | 54 | | 88 | | | | 22 | | | 27 | | | |
| 20-03-18 | MSMODE | 2664 | 63 | | | | 60 | | 124 | | | | 20 | | | | | | |
| 19-03-18 | MSMODE | 3288 | 108 | | | | 67 | | 35 | | | 93 | - | | | | | | |
| 18-03-18 | OKAIDI | 4644 | 97 | | - | | 101 | | 82 | | | 43 | - | | | 51 | | | |
| 17-03-18 | OKAIDI | 5474 | 44 | | 54 | | 28 | | 105 | | | 52 | - | | | 21 | | | |
| 15-03-18 | OKAIDI | 4465 | 75 | | 85 | | 49 | | 86 | | | 51 | - | | | 39 | | | |
| Total | TOTAL | 24089 | 450 | | 139 | | 359 | | 520 | | | 239 | 42 | | | 111 | | | |
| | TOTAL FAULT | 1860 | | | | | | | | | | | | | | | | | |
| | DEFECT% | 7.72% | | | | | | | | | | | | | | | | | |
| Defect % | | | 24.19 | | 7.47 | | | | 27.95 | | | 12.84 | 2.25 | | | 5.96 | | | |

Here is the highest defects % **27.95** dirty spot.

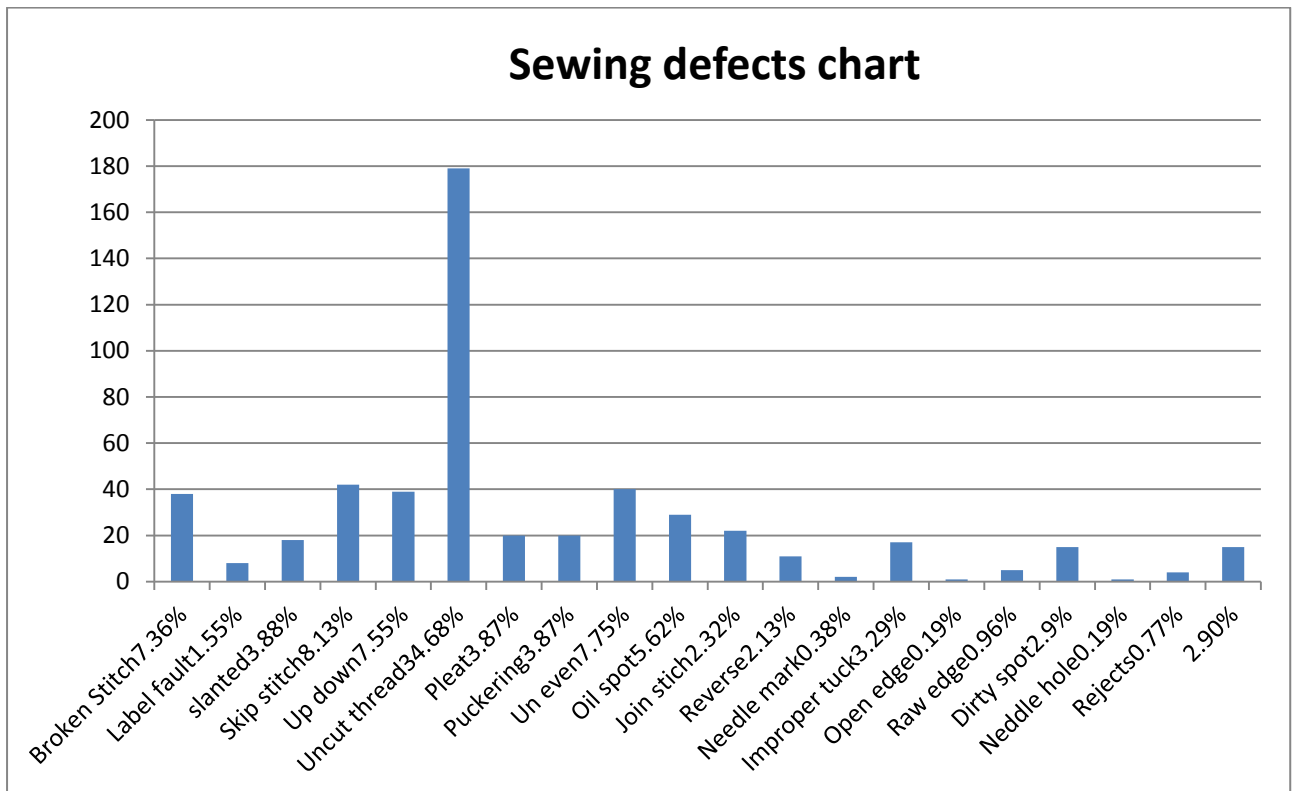
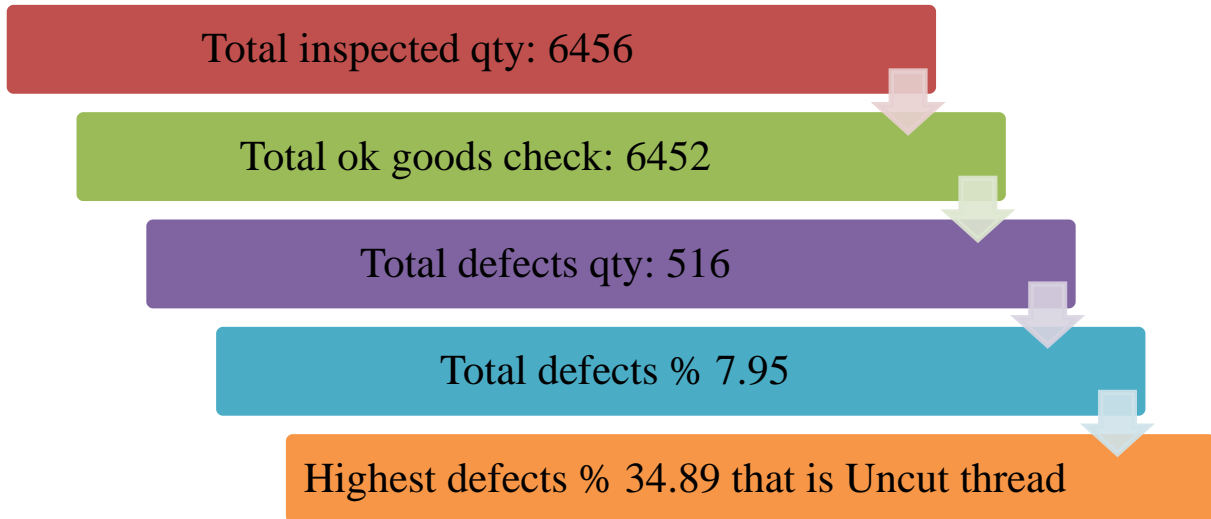
Chapter: 4

Results & Discussion

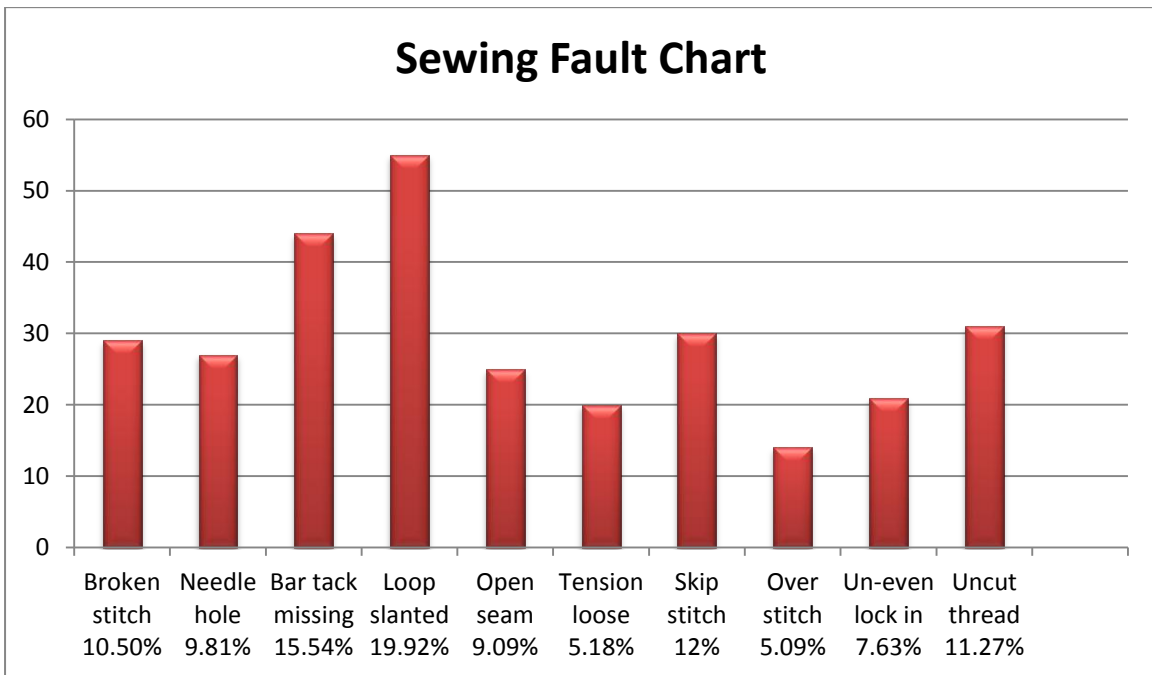
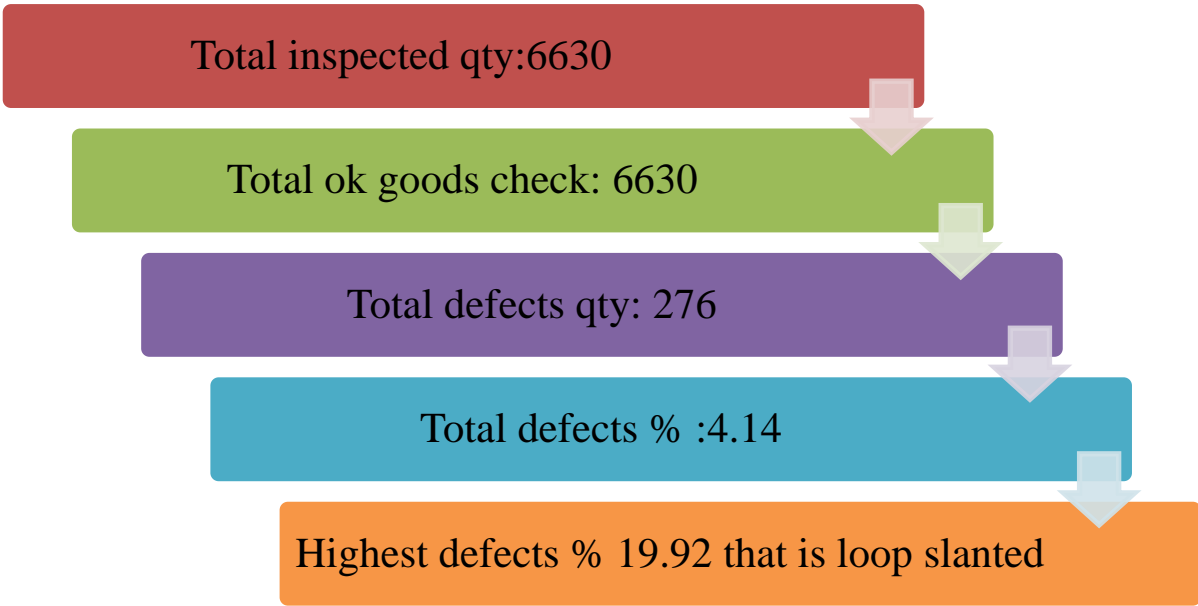
4.1 Results:

4.1.1 Sewing section data :

a) Aman tex

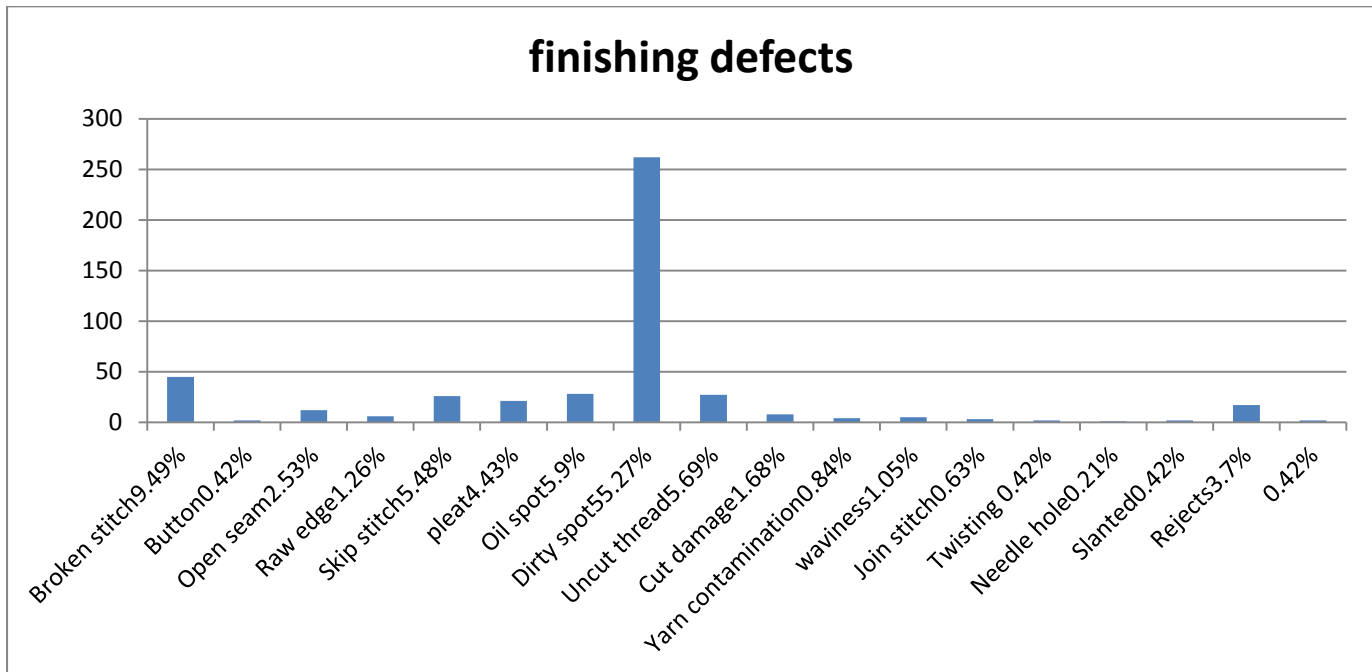
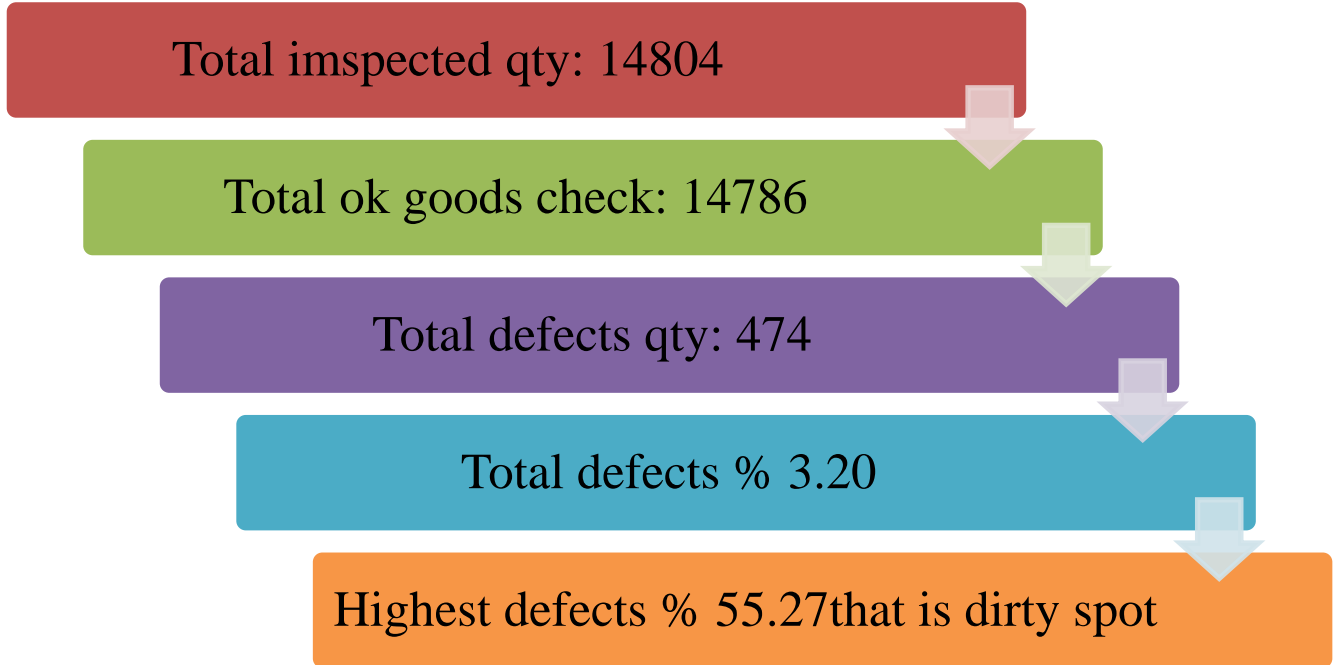


b) Fair Trade Group

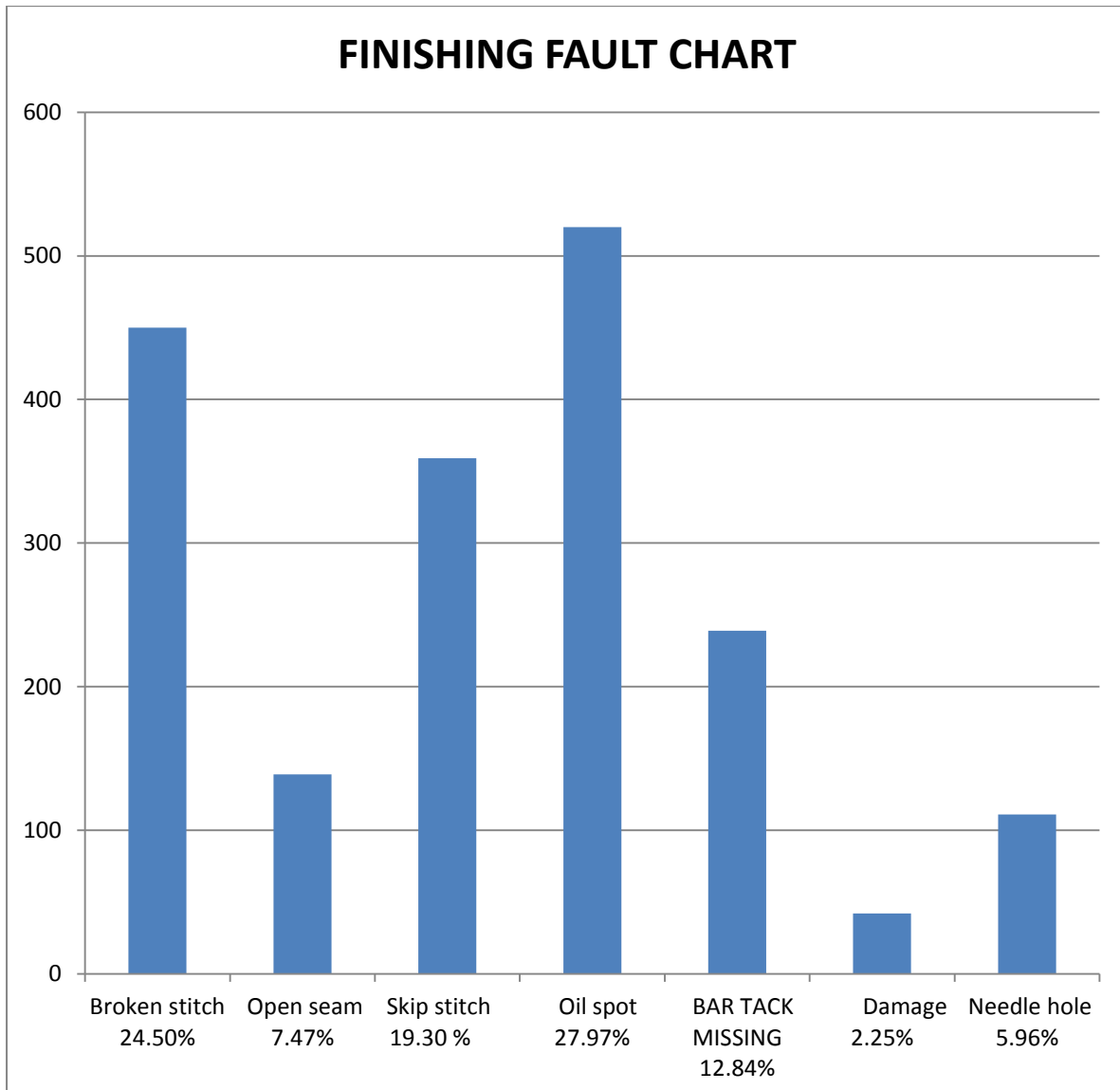
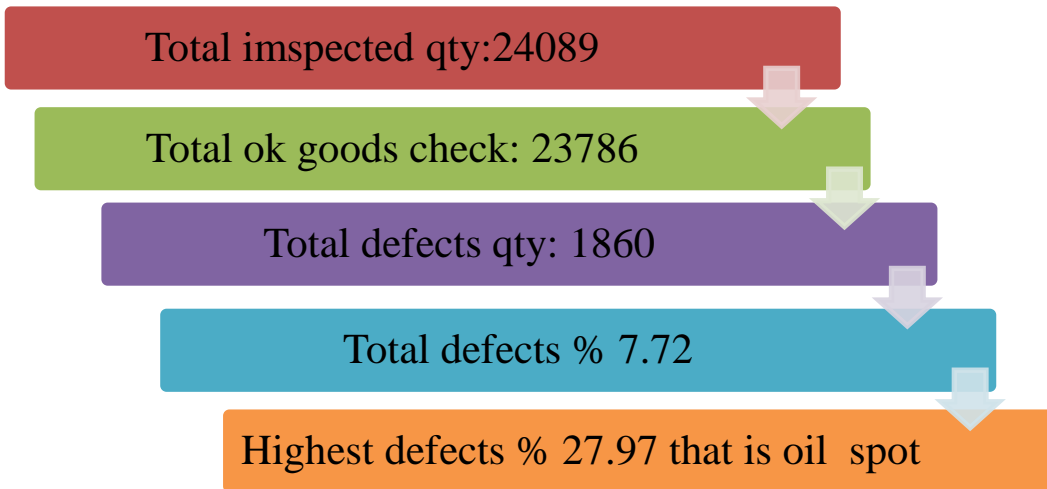


4.1.2 In finishing section:

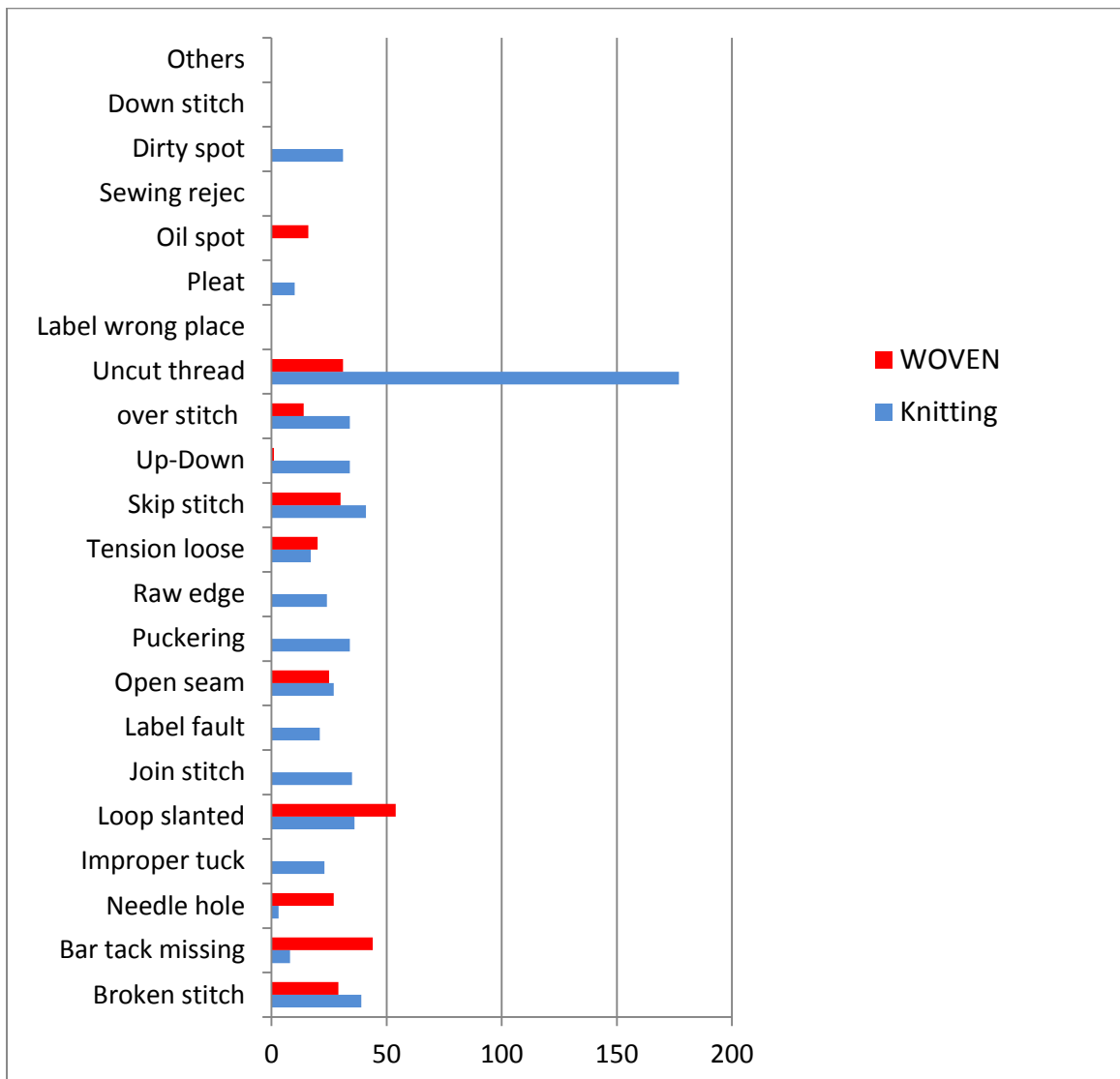
a) Aman tex ltd



b) Fair Trade Group

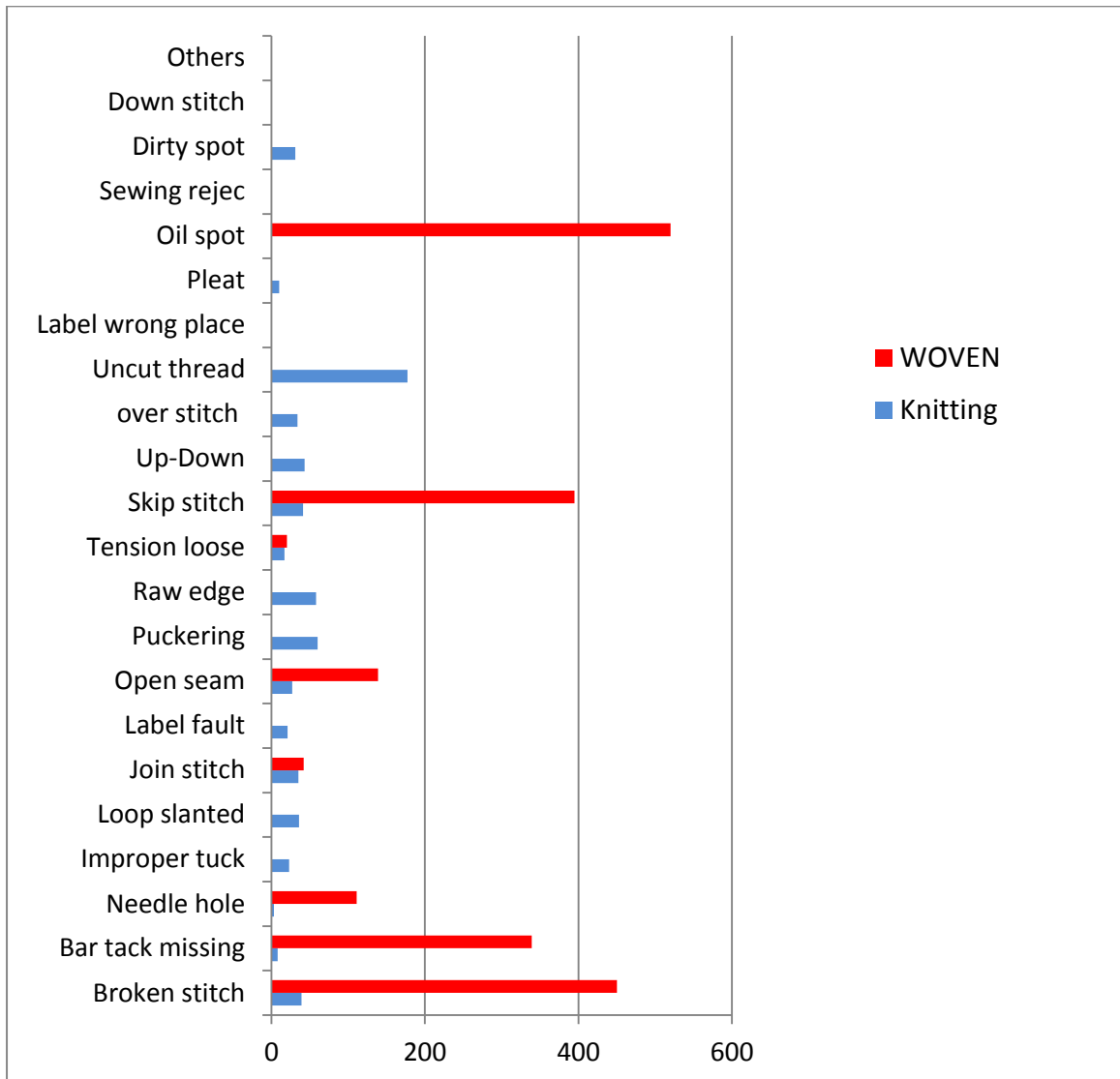


4.2.1 Comparison graph of Sewing Faults between Two Industries:



This bar graph presenting amount the faults different that occurring in sewing floor during sewing operation of two factory in where we study and observed. Long bar show maximum amount of faults and short length show minimum amount of faults. Red color use for **WOVEN** . and Blue color use for **KNITTING** comparison.

4.2.2 Comparison graph of Sewing Finishing between Two Industries:



This bar graph presenting amount the faults different that occurring in sewing floor during sewing operation of two factory in where we study and observed. Long bar show maximum amount of faults and short length show minimum amount of faults. Red color use for WOVEN . and Blue color use for KNITTING for comparison

4.3 Discussion:

In Sewing Section

b) In Aman Tex Ltd. we also observed and collected data for 6 working days in different line. In this industry we also observe that, totally 6456 pieces garments are inspected, and found that ok goods are 6452 pieces, defective goods found 516 pieces, , which can be rectify

a) In Fair Trade Group we observing & collected data for 6 working days in different line. In there we observed that, totally 6630 pieces garments are inspected, in where ok goods are 6628 pieces, defective garments are 276 pieces, it will be recoverable.

In Finishing section :

a) In Aman Tex Ltd. we also observed and collected data for 6 working days in different line. In this industry we also observe that, totally 14804 pieces garments are inspected, and found that ok goods are 17786 pieces, defective goods found 474 pieces, , which can be rectify

b) In Fair Trade Group we observing & collected data for 6 working days in different line. In there we observed that, totally 24089 pieces garments are inspected, in where ok goods are 23786 pieces, defective garments are 1860 pieces, it will be recoverable.

CHAPTER-5

FINDINGS AND SUGGESTIONS

5.1 FINDINGS:

- The uncut thread and loop slanted contribute about 34.64% and 19.92% of the total defects based on the number of defects of Knitting and woven garments in sewing section
- The dirty oil and oil spot 55.27% contribute about % and 27.97 % of the total defects based on the number of defects of Knitting and woven garments in sewing section
- Irrespective of knitting and woven defects are not same . Nearly more defects are occurring of Knitting garments in sewing section
- Irrespective of knitting and woven defects are not same . Nearly more defects are occurring of woven garments in finishing section

5.2 SUGGESTIONS:

- Currently the total defects margin is around **7.96 ,4.14 ,3.20 .7.96** of the entire production respectively in sewing and finishing section . If we can cut down the top 3 defects from the entire process it can bring down the total defects under Standard acceptable defects margin. The total defects margin will come down which is below the Standard acceptable defects margin .

Therefore ,we can produced quality goods to eliminate top 3 defects

To eliminating defects given below some suggestion

- For machineries and equipment's continuous assessment and maintenance is needed.
- The technician can be appointed and he must keenly check the threads, needle ,and tension of the machine frequently according to the fabric texture
- The machines should be cleaned and maintained by that technician frequently

Chapter: 6

Conclusion

From this study, the most occurring defects and its frequency of occurrence have been identified. It is suggested that the company can concentrate on these defects mainly and take steps to bring down and this will pay way for increasing the level of productivity and save the time

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Appendix

Amantex Limited
Bolragirchala, Sreepur, Gazipur

DHU % = $\frac{\text{TI defects qty}}{\text{X100}} \times \frac{\text{TI check qty}}$

Date: 24.09.17
DHU AVG% 7.88%

Hourly DHU Report (At Sewing QC table)

Order No: 2017-17-792 Style Name: SIBAFLOW02 Color: RA
 Floor No: 02 Line No: 04 Table Quality Name: UH1

Buyer: SPORTMASTER

| Defects Name | Hour | | | | | | | | | | Total |
|---------------------------------|-------|--------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | | | | | | | | | 1 | 111 | 05 |
| Button/Snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut Damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | 11 | 1 | 1 | 1 | 1 | 1 | | | | 07 |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | | | | | | | | |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Rawedge | | | | | | | | | | | |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | 11 | 11 | | 111 | 111 | 11 | 14 |
| Zip stitch | 1 | | | | | | | | | | 01 |
| Shading | | | | | | | | | | | |
| Stripe Not Match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up-down | | | 1 | 1 | 11 | | | 11 | 1 | | 07 |
| Un-even | | | | | | | | | | | |
| Uncut thread | 111 | 111 | 11 | 111 | 111 | 11 | 111 | 111 | | | 31 |
| Wavyness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong Placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | 111 | 11 | 03 |
| Placket | | | | | | | | | | | |
| Pocket | | | | | | | | | | | |
| Leat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | | | | | |
| Dirty spot | | | | | | | | | | | |
| Rejects | | | | | | | | 11 | 1 | 1 | 04 |
| Others | | 11 | | | | | | | | 11 | 04 |
| Total check gmts | 75 | 80 | 80 | 85 | 85 | 90 | 90 | 172 | 174 | 172 | 1104 |
| Total Pass gmts | 75 | 80 | 80 | 85 | 85 | 90 | 90 | 170 | 173 | 171 | 1100 |
| Total defectives gmts | 05 | 08 | 04 | 05 | 08 | 04 | 05 | 13 | 12 | 12 | 76 |
| Total defects qty | 05 | 08 | 04 | 05 | 08 | 05 | 06 | 13 | 12 | 12 | 81 |
| DHU% | 5% | 11.25% | 5% | 7.05% | 9.41% | 5.55% | 7.05% | 7.55% | 6.89% | 6.97% | 7.33% |
| defectives rectified qty | 05 | 08 | 04 | 05 | 08 | 04 | 05 | 13 | 12 | 12 | 76 |
| defectives balance qty | | | | | | | | 02 | 01 | 01 | 04 |
| Rectify defectives check & pass | 05 | 08 | 04 | 05 | 08 | 04 | 05 | 11 | 11 | 11 | 72 |
| Rejects qty | | | | | | | | 02 | 01 | 01 | 04 |
| Supervisor signature | | | | | | | | | | | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|---------------|------------------|--------------------|--------------------|---------------------|
| UNSEPT THREAD | HELPER PROBLEM | ie. sv are machine | HELPER | 25-09-17 |
| SLANTED | OPERATOR PROBLEM | ie. sv are machine | OPERATOR | 25-09-17 |
| SLANTED | OPERATOR PROBLEM | ie. sv are machine | OPERATOR | 25-09-17 |

Quality Controller: QC.Incharge: Floor Incharge: APM/DPM: PM: QM:

Amantex Limited
BOIRAGIRCHALA, SREEPUR, GAZIPUR

DHU % = TI defects qty X100
TI check qty

Date : 26-01-18
DHU AVG% 19.33%

Hourly DHU Report (At Sewing QC table)

Order No: 30A05D02 Style Name: TAZ TEE Color: GREEN DARK
 Floor No: U-3 Line No: 22 Table Quality Name: MAROJA
 Buyer :- HBM A0-17-1566

| Defects Name | Hour | | | | | | | | | | Total |
|---------------------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|--------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | NILL | NILL | 1 | | 1 | 1 | 1 | 1 | | | 07 |
| Button/Snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut Damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | | | | | | | | |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 12 |
| Rawedge | | | | | | | | | | | |
| Reverse | | | | | | | | | | | |
| inted | | | | | | | | | | | |
| Skip stitch | | | | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 11 |
| Shading | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up-down | NILL | NILL | | | 1 | 1 | | | | | 03 |
| Un-even | | | | | | | | | | | |
| Uncut thread | | | 1 | | 1 | | 1 | 1 | | | 06 |
| Wavyness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong Placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Pocket | | | | | | | | | | | |
| at | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 10 |
| Dirty spot | | | | | | | | | | | |
| Rejects | | | | | | | | | | | |
| Pressing Defect | | | | | | | | | | | |
| Losse Thread | | | | | | | | | | | |
| Poor Ironing Shape | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| Total check gmts | NILL | NILL | 15 | 10 | 60 | 70 | 70 | 45 | | | 300 |
| Total Pass gmts | | | 15 | 10 | 60 | 70 | 70 | 45 | | | 300 |
| Total defectives gmts | | | 03 | 06 | 12 | 12 | 13 | 11 | | | 58 |
| Total defects qty | | | 03 | 06 | 12 | 12 | 13 | 11 | | | 58 |
| DHU% | | | 20% | 15% | 20% | 14% | 18.5% | 24.4% | | | 19.33% |
| defectives rectified qty | | | 03 | 06 | 12 | 12 | 13 | 11 | | | 58 |
| defectives balance qty | | | | | | | | | | | |
| Rectify defectives check & pass | | | 03 | 06 | 12 | 12 | 13 | 11 | | | 58 |
| Rejects qty | | | | | | | | | | | |
| Supervisor signature | | | | | | | | | | | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|-------------------------|-----------------|-----------------------|--------------------|---------------------|
| 1. OIL SPOT - 19 Pcs | Machine setting | Check machine setting | M.K/A.P.M | 27-01-18 |
| 2. Puckering - 12 Pcs | Machine setting | Check machine setting | M.K/A.P.M | 11 |
| 3. SKIP STITCH - 11 Pcs | Machine setting | Check machine setting | M.K/A.P.M | 11 |

Quality Controller

QC. Incharge

Floor Incharge

APM/DPM

PM

QM

A.T.L-18-15 (m)

Amantex Limited
BOIRAGIRCHALA, SREEPUR, GAZIPUR

DHU % = TI defects qty X100
TI check qty

Hourly DHU Report (At Sewing QC table)

Date: 27.01.18
DHU AVG% 9.90%

Order No: 274274 Style Name: RONNY Color: GERY
 Floor No: 0-3 Line No: 08 Table Quality Name: ZABER / ASMA
 Buyer: H8M

| Defects Name | Hour | | | | | | | | | | Total |
|---------------------------------|--------|-------|-------|--------|--------|-------|-------|--------|-------|-------|-------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | | 1 | | | | 1 | 1 | 1 | 1 | | 6 |
| Button/Snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut Damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | 1 | 1 | 1 | 1 | | 1 | | 1 | | | 10 |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | 1 | 1 | 1 | | | | | | | | 3 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | 1 | 1 | | 1 | 1 | 1 | 1 | 1 | | | 8 |
| Rawedge | 1 | 1 | | 1 | 1 | 1 | 1 | 1 | | | 8 |
| Reverse | | | | | | | | | | | |
| Skipped | | | | | | | | | | | |
| Skipped | | | | | | | | | | | |
| Skip stitch | 1 | 1 | | | | | | | | | 2 |
| Shading | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up-down | | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1 | | 9 |
| Un-even | | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1 | | 9 |
| Uncut thread | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 10 |
| Wavyness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong Placement | | | | | | | | | | | |
| Yam contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Pocket | | | | | | | | | | | |
| Waist | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | | | | | |
| Dirty spot | | | | 1 | 1 | | | | | | 2 |
| Rejects | | | | | | | | | | | |
| Pressing Defect | | | | | | | | | | | |
| Loose Thread | | | | | | | | | | | |
| Poor Ironing Shape | | | | | | | | | | | |
| Others | 1 | | | 1 | 1 | 1 | | 1 | | | 6 |
| Total check gmts | 90 | 160 | 150 | 140 | 150 | 170 | 160 | 110 | | | 1070 |
| Total Pass gmts | 90 | 160 | 150 | 140 | 150 | 170 | 160 | 110 | | | 1070 |
| Total defectives gmts | 10 | 14 | 12 | 16 | 17 | 13 | 10 | 14 | | | 106 |
| Total defects qty | 10 | 14 | 12 | 16 | 17 | 13 | 10 | 14 | | | 106 |
| DHU% | 11.11% | 8.75% | 8% | 11.42% | 11.33% | 7.64% | 6.25% | 12.72% | | | 9.90% |
| defectives rectified qty | 10 | 14 | 12 | 16 | 17 | 13 | 10 | 14 | | | 106 |
| defectives balance qty | | | | | | | | | | | |
| Rectify defectives check & pass | 10 | 14 | 12 | 16 | 17 | 13 | 10 | 14 | | | 106 |
| Rejects qty | | | | | | | | | | | |
| Supervisor signature | | | | | | | | | | | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|----------------|-------------------|--------|--------------------|---------------------|
| UP-DOWN = 9 | HEAVY WORKLOAD | ADD ST | HEAVY WORKLOAD | 27.01.18 |
| UN-EVEN = 9 | OPERATOR WORKLOAD | LS | OPERATOR WORKLOAD | " |
| SOFT SPIN = 10 | " | SV | " | " |

Quality Controller: QC. Incharge: Floor Incharge: APM/DPM: PM: QM:

Amantex Limited

BOIRAGIRCHALA, SREEPUR, GAZIPUR

Hourly DHU Report (At Sewing QC table)

DHU % = $\frac{\text{Total Defects Qty}}{\text{Total Check Qty}} \times 100$

Date: 28-01-18

DHU AVG% 11.92%

| | | |
|-------------------|------------------|------------------------------------|
| Order No: 272275 | Style Name: LIMA | Color: BLUE REDDISH DARK |
| Floor No: U-3 | Line No: 23 | Table Quality Name: AMANA / RASHED |
| Buyer: H.M. 18.08 | | |

| Defects Name | Hour | | | | | | | | | | Total |
|---------------------------------|--------------|-------|--------|--------|-------|--------|-------|-------|-------|-------|--------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | 1 | | | | | | | | | | 06 |
| Button/Snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut Damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | 11 | 11 | 1 | | | 11 | | | 1 | | 10 |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | | 1 | | 1 | | | | 02 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Rawedge | | | | | | | | | | | |
| Reverse | 11 | 11 | 1 | 1 | | | 1 | | | | 10 |
| nted | | | | | | | | | | | |
| Skip stitch | | | | | 11 | 1 | | | | 1 | 04 |
| Shading | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up-down | 11 | 11 | 7 | 11 | 1 | | 1 | 1 | | 11 | 15 |
| Un-even | | | | | | | | | | | |
| Uncut thread | 1 | 11 | 11 | 11 | 11 | 11 | 11 | 11 | 11 | 11 | 95 |
| Wavyness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong Placement | | | 11 | | | | | | | | 02 |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Pocket | | | | | | | | | | | |
| at | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | 1 | 1 | 11 | 1 | | 05 |
| Dirty spot | | | | | | | | | | | |
| Rejects | | | | | | | | | | | |
| Pressing Defect | | | | | | | | | | | |
| Losse Thread | | | | | | | | | | | |
| Poor Ironing Shape | | | | | | | | | | | |
| Others | | | | | | | 1 | 1 | 1 | | 03 |
| Total check gmts | 20 | 25 | 30 | 30 | 110 | 30 | 120 | 110 | 130 | 110 | 865 |
| Total Pass gmts | 20 | 25 | 30 | 30 | 110 | 30 | 120 | 110 | 130 | 110 | 865 |
| Total defectives gmts | 16 | 9 | 8 | 10 | 7 | 12 | 10 | 9 | 11 | 11 | 102 |
| Total defectives qty | 16 | 9 | 8 | 10 | 7 | 12 | 10 | 9 | 11 | 11 | 102 |
| DHU% | 80.0% | 36% | 11.42% | 11.11% | 6.36% | 17.14% | 8.33% | 8.18% | 8.46% | 10% | 11.92% |
| defectives rectified qty | 16 | 9 | 8 | 10 | 7 | 12 | 10 | 9 | 11 | 11 | 102 |
| defectives balance qty | - | - | - | - | - | - | - | - | - | - | - |
| Rectify defectives check & pass | 16 | 9 | 8 | 10 | 7 | 12 | 10 | 9 | 11 | 11 | 102 |
| Rejects qty | | | | | | | | | | | |
| Supervisor signature | [Signatures] | | | | | | | | | | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|--------------------------|--------------------|--------------------------------|--------------------|---------------------|
| 1. uncut thread - 45 pcs | (কম্পিউটার সমস্যা) | কম্পিউটার সফটওয়্যার আপডেট করা | L.C/S.V | 28-1-18 |
| 2. UPDOWN - 15 PCS | কম্পিউটার সমস্যা | কম্পিউটার সফটওয়্যার আপডেট করা | L.C/S.V | 28-1-18 |
| 3. RAW EDGES - 10 PCS | কম্পিউটার সমস্যা | কম্পিউটার সফটওয়্যার আপডেট করা | L.C/S.V | 28-1-18 |

Quality Controller: [Signature] Incharge: [Signature] Floor Incharge: [Signature] APM/DPM: [Signature] PM: [Signature]

Amantex Limited
BOIRAGIRCHALA, SREEPUR, GAZIPUR

DHU % = TU defects qty X100
TU check qty
Date: 29-01-18
DHU AVG% 10.56%

Hourly DHU Report (At Sewing QC table)

Order No: 272275 Style Name: LIMA Color:
 Floor No: U-3 Line No: 23 Table Quality Name: AMANA/RASHED

Buyer :- H M 18.08

| Defects Name | Hour | | | | | | | | | | Total |
|---------------------------------|-------|-------|-------|-------|-------|-------|-------|-------|---------|-------|--------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | 1 | | | | | | | | | | 02 |
| Button/Snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut Damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | 1 | 1 | | | | | | | | | 02 |
| Label fault | | | | | | | | | | | |
| Needle mark | | 1 | 1 | | | | | | | | 02 |
| Open seam | | | | | | | | | | | |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Rawedge | | | | | | | | | | | |
| Reverse | | 1 | | | | | | | | | 01 |
| nted | | | | | | | | | | | |
| Skip stitch | 11 | 1 | | | | | | | | | 03 |
| Shading | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up-down | | | | | | | | | | | |
| Un-even | | | | | | | | | | | |
| Uncut thread | 1111 | 1111 | 1111 | | | | | | | | 12 |
| Wavyness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong Placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Pocket | | | | | | | | | | | |
| at | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | 1 | | 1 | | | | | | | | 02 |
| Dirty spot | | | | | | | | | | | |
| Rejects | | | | | | | | | | | |
| Pressing Defect | | | | | | | | | | | |
| Losse Thread | | | | | | | | | | | |
| Poor Ironing Shape | | | | | | | | | | | |
| Others | | | 1 | | | | | | | | 01 |
| Total check gmts | 130 | 130 | 135 | | | | | | 855+395 | | 1250 |
| Total Pass gmts | 130 | 130 | 135 | | | | | | 855+395 | | 1250 |
| Total defectives gmts | 9 | 10 | 11 | | | | | | 102+30 | | 132 |
| Total defects qty | 9 | 10 | 11 | | | | | | 102+30 | | 132 |
| DHU% | 6.92% | 7.69% | 8.14% | | | | | | | | 10.56% |
| defectives rectified qty | 9 | 10 | 11 | | | | | | 102+30 | | 132 |
| defectives balance qty | - | - | - | | | | | | - | | - |
| Rectify defectives check & pass | 9 | 10 | 11 | | | | | | 102+30 | | 132 |
| Rejects qty | | | | | | | | | | | |
| Supervisor signature | | | | | | | | | | | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|---------------|------------|-----|--------------------|---------------------|
| | | | | |
| | | | | |
| | | | | |

Quality Controller Incharge Floor Incharge APM/DPM QM

[Type

Amantex Limited

BOIRAGIRCHALA, SREEPUR, GAZIPUR

Hourly DHU Report (At Sewing QC table)

DHU % = TII defects qty X100
TII check qty

Date: 30-07-18 ✓
DHU AVG% 77.64%

| | | |
|-------------------------|----------------------------|---------------------------------|
| Order No: 266642 | Style Name: BOB V-NECK TEE | Color: WHITE |
| Floor No: 03 RD'17-1799 | Line No: 11 | Table Quality Name: EASY-CATANA |

| Defects Name | Hour | | | | | | | | | | Total |
|---------------------------------|-------|--------|--------|--------|--------|--------|-------|-------|--------|--------|--------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | /// | /// | | | 1 | 1 | | | 1 | | 09 |
| Button/Snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | 11 | | 1 | 03 |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut Damage | | | | | | | | | | | |
| Improper tuck | | 1 | 1 | 1 | 1 | /// | | 11 | /// | /// | 17 |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | 1 | | | | | | | | 01 |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | 1 | | | | | | | 01 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| wedge | | 1 | | | | 1 | 1 | | 11 | | 06 |
| Reverse | | | | | | | | | | | |
| Skipped | 1 | 1 | | | | | 11 | | | | 04 |
| Skip stitch | | /// | | /// | /// | /// | /// | | 1 | 1 | 20 |
| Shading | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up-down | | | | | | | | | | | |
| Un-even | 1 | 11 | /// | /// | | /// | 11 | 11 | 1 | 11 | 22 |
| Uncut thread | /// | /// | /// | /// | /// | /// | /// | /// | /// | /// | 18 |
| Wavyness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong Placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| ocket | | | | | | | | | | | |
| Pocket | | | | | | | | | | | |
| Plat | | | /// | 1 | 11 | 1 | 11 | | | 11 | 32 |
| Je band | | | | | | | | | | | |
| Oil spot | | | | | | | | | | | |
| Dirty spot | | | 11 | 1 | 11 | 11 | | 11 | 11 | 11 | 14 |
| Rejects | | | | | | | | | | | |
| Pressing Defect | | | | | | | | | | | |
| Losse Thread | | | | | | | | | | | |
| Poor Ironing Shape | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| Total check gmts | 100 | 120 | 130 | 122 | 130 | 140 | 140 | 130 | 120 | 160 | 1340 |
| Total Pass gmts | 100 | 120 | 130 | 120 | 130 | 140 | 140 | 130 | 110 | 160 | 1340 |
| Total defectives gmts | 06 | 12 | 12 | 22 | 10 | 13 | 11 | 10 | 16 | 16 | 127 |
| Total defects qty | 09 | 14 | 16 | 26 | 14 | 16 | 14 | 13 | 19 | 17 | 166 |
| DHU% | 9% | 11.66% | 11.53% | 20.83% | 10.76% | 11.42% | 10% | 10% | 11.78% | 10.62% | 11.64% |
| defectives rectified qty | 06 | 12 | 12 | 22 | 10 | 13 | 11 | 10 | 16 | 16 | 127 |
| defectives balance qty | | | | | | | | | | | |
| Rectify defectives check & pass | 06 | 12 | 12 | 22 | 10 | 13 | 11 | 10 | 16 | 16 | 127 |
| Rejects qty | | | | | | | | | | | |
| Supervisor signature | | | | | | | | | | | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|------------------|-------------|-----------|--------------------|---------------------|
| un cut thread-18 | HIP-PROBLEM | DEFECTIVE | L.C, A.P.M | 28-1-18 |
| un-even-22 | HIP-PROBLEM | | | |
| SKIP STITCH-20 | HVC PROBLEM | | | |

Quality Controller: [Signature] QC. Incharge: [Signature] Floor Incharge: [Signature] ARMD/PM: [Signature] PM: [Signature] QM: [Signature]

Amantex Limited
Boiragirchala, Sreepur, Gazipur

DHU % = TI defects qty X100
TI check qty







Hourly DHU Report (At Finishing QC table)

Date: 22-10-17
DHU AVG% 5.92%

| | | | | | |
|-----------|----------------|-------------|-----|---------------------|---------------|
| Order No: | 17-1804/223256 | Style Name: | LEE | Color: | white |
| Floor No: | U-3 | Line No: | 18 | Table Quality Name: | IRUNA/MARZINA |

| Defects Name | Hour | | | | | | | | | | Total |
|---------------------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | | III | II | | II | I | | III | II | II | 18 |
| Button/Snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | I | | | | | | | I | | | 02 |
| Cut Damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | I | | | | | | | I | II | | 06 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Rawedge | I | | | | | | | | I | | 02 |
| Reverse | | | | | | | | | | | |
| lanted | | | | | | | | | | | |
| Skip stitch | I | I | | | | | | | | | 06 |
| Shading | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up-down | | | | | | | | | | | |
| Un-even | | | | | | | | | | | |
| Uncut thread | | | | | | | | | | | |
| Wavyness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong Placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Pocket | | | | | | | | | | | |
| leat | I | II | I | II | II | I | II | | | | 11 |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | | | | | |
| Dirty spot | III | III | III | III | III | III | II | | | | 26 |
| Rejects | | | | | | | | | | | 03 |
| Pressing Defect | | | | | | | | | | | |
| Loose Thread | | | | | | | | | | | |
| Poor Ironing Shape | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| Total check gmts | 120 | 140 | 120 | 120 | 150 | 120 | 130 | 180 | 120 | 130 | 1250 |
| Total Pass gmts | 120 | 140 | 120 | 119 | 150 | 120 | 140 | 98 | 120 | 130 | 1247 |
| Total defectives gmts | 06 | 09 | 08 | 05 | 07 | 17 | 05 | 08 | 06 | 05 | 65 |
| Total defects qty | 23 | 11 | 08 | 06 | 09 | 07 | 06 | 02 | 06 | 05 | 74 |
| DHU% | 6.66% | 7.85% | 6.66% | 5% | 6% | 5.83% | 4.61% | 3% | 5% | 3.84% | 5.92% |
| defectives rectified qty | 06 | 09 | 08 | 04 | 07 | 07 | 05 | 04 | 05 | 06 | 61 |
| defectives balance qty | - | - | - | - | - | - | - | - | - | - | - |
| Rectify defectives check & pass | 06 | 05 | 08 | 04 | 07 | 07 | 05 | 06 | 05 | 06 | 61 |
| Rejects qty | | | | | | | | | | | |
| Supervisor signature | | | | | | | | | | | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|--------------------|---------------------|----------------------------|--------------------|---------------------|
| Dirty Spot (26) | Hand touch / fabric | work place clean use paper | S.V. S. C. H/C | 22-10-17 |
| Broken stitch (18) | sp/needle problem | training sp/needle | L. S. V. G | " |
| Placket (11) | sp/needle problem | sp/needle | S.V. S. C. H/C | " |

 Quality Controller
  QC Incharge
  Floor Incharge
  APM/DPM
  PM
  QM

Amantex Limited
Boiragirchala, Sreepur, Gazipur

DHU % = $\frac{\text{TD defects qty} \times 100}{\text{TD check qty}}$

Hourly DHU Report (At Finishing QC table)

Date: 22-10-17
DHU AVG% 5.92%

Order No: 10-17-1004/223256 Style Name: LEE Color: white
 Floor No: U-2 Line No: 18 Table Quality Name: IRINA / MARZINA

| Defects Name | Hour | | | | | | | | | | | Total |
|---------------------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | | |
| Broken stitch | | | | | | | | | | | | 18 |
| Button/Snap/Adjustable | | | | | | | | | | | | |
| Button hole | | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | | 02 |
| Cut Damage | | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | | |
| Label fault | | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | | |
| Open seam | | | | | | | | | | | | 06 |
| Print fault | | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | | |
| Puckering | | | | | | | | | | | | |
| Rawedge | | | | | | | | | | | | 02 |
| Reverse | | | | | | | | | | | | |
| lanted | | | | | | | | | | | | |
| Skip stitch | | | | | | | | | | | | 05 |
| Shading | | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | | |
| Twisting | | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | | |
| Up-down | | | | | | | | | | | | |
| Un-even | | | | | | | | | | | | |
| Uncut thread | | | | | | | | | | | | |
| Wavyness | | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | | |
| Label wrong Placement | | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | | |
| Collar | | | | | | | | | | | | |
| Placket | | | | | | | | | | | | |
| Pocket | | | | | | | | | | | | |
| leat | | | | | | | | | | | | 11 |
| Side band | | | | | | | | | | | | |
| Oil spot | | | | | | | | | | | | |
| Dirty spot | | | | | | | | | | | | 26 |
| Rejects | | | | | | | | | | | | 03 |
| Pressing Defect | | | | | | | | | | | | |
| Loose Thread | | | | | | | | | | | | |
| Poor Ironing Shape | | | | | | | | | | | | |
| Others | | | | | | | | | | | | |
| Total check gmts | 120 | 140 | 120 | 120 | 150 | 120 | 130 | 160 | 120 | 130 | 120 | 1260 |
| Total Pass gmts | 120 | 140 | 120 | 119 | 150 | 120 | 130 | 158 | 120 | 130 | 120 | 1247 |
| Total defectives gmts | 06 | 09 | 08 | 05 | 07 | 17 | 05 | 02 | 06 | 05 | 05 | 65 |
| Total defects qty | 08 | 11 | 08 | 06 | 07 | 07 | 06 | 02 | 06 | 05 | 05 | 74 |
| DHU% | 6.66% | 7.85% | 6.66% | 5% | 6% | 5.83% | 4.21% | 3% | 5% | 3.84% | 5.92% | |
| defectives rectified qty | 06 | 09 | 08 | 04 | 07 | 07 | 05 | 05 | 05 | 05 | 05 | 61 |
| defectives balance qty | - | - | - | - | - | - | - | - | - | - | - | - |
| Rectify defectives check & pass | 06 | 05 | 08 | 04 | 07 | 07 | 05 | 05 | 05 | 05 | 05 | 61 |
| Rejects qty | | | | | | | | | | | | |
| Supervisor signature | | | | | | | | | | | | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|--------------------|----------------------|------------------------|--------------------|---------------------|
| Dirty Spot (26) | Hand print on fabric | Wash fabric before use | S.V. S. S. S. | 22-10-17 |
| Broken stitch (18) | Spalling of needle | Training of operator | L. S. S. | " |
| Placket (11) | Operator negligence | Training of operator | S.V. S. S. | " |

Quality Controller: QC.Incharge: Floor Incharge: APM/DPM: PM: QM:

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DHU % = $\frac{\text{Til defects qty} \times 100}{\text{Til check qty}}$

Hourly DHU Report (At Finishing QC table)

Date: 13-1-18
DHU AVG% 3.28%

Order No: 152534
Floor No: 0-02
Buyer: VEKO MODA
Style Name: 10196086
Line No: 15
Table Quality Name: Marheic
Color: BLACK

| Defects Name | Hour | | | | | | | | | | | Total |
|---------------------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | | |
| Broken stitch | | | | | | | | | | | | 2 |
| Button/Snap/Adjustable | | | | | | | | | | | | |
| Button hole | | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | | |
| Cut Damage | | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | | |
| Label fault | | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | | |
| Open seam | | | | | | | | | | | | |
| Print fault | | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | | |
| Puckering | | | | | | | | | | | | |
| Rawedge | | | | | | | | | | | | |
| Reverse | | | | | | | | | | | | |
| Slanted | | | | | | | | | | | | |
| Skip stitch | | | | | | | | | | | | 4 |
| Shading | | | | | | | | | | | | |
| hread mistake | | | | | | | | | | | | |
| Twisting | | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | | |
| Up-down | | | | | | | | | | | | |
| Un-even | | | | | | | | | | | | |
| Uncut thread | | | | | | | | | | | | 20 |
| Wavyness | | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | | |
| Label wrong Placement | | | | | | | | | | | | |
| Yam contamination | | | | | | | | | | | | |
| Collar | | | | | | | | | | | | |
| Placket | | | | | | | | | | | | |
| Pocket | | | | | | | | | | | | |
| Pleat | | | | | | | | | | | | 3 |
| Side band | | | | | | | | | | | | |
| Spot | | | | | | | | | | | | |
| Dirty spot | | | | | | | | | | | | 16 |
| Rejects | | | | | | | | | | | | 1 |
| Pressing Defect | | | | | | | | | | | | |
| Losse Thread | | | | | | | | | | | | |
| Poor Ironing Shape | | | | | | | | | | | | |
| Others | | | | | | | | | | | | |
| Total check gmts | 100 | 100 | 100 | 120 | 120 | 100 | 100 | 220 | 220 | 220 | 1400 | |
| Total Pass gmts | 99 | 100 | 100 | 120 | 120 | 100 | 100 | 220 | 220 | 220 | 1399 | |
| Total defectives gmts | 1 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 1 | |
| Total defectives qty | 5 | 4 | 5 | 4 | 5 | 3 | 3 | 6 | 6 | 5 | 46 | |
| DHU% | 5% | 4% | 5% | 3.33% | 4.16% | 3% | 3% | 2.72% | 2.72% | 2.27% | 3.28% | |
| defectives rectified qty | 4 | 4 | 5 | 4 | 5 | 3 | 3 | 6 | 6 | 5 | 46 | |
| defectives balance qty | 1 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | |
| Rectify defectives check & pass | 4 | 4 | 5 | 4 | 5 | 3 | 3 | 6 | 6 | 5 | 46 | |
| Rejects qty | | | | | | | | | | | | |
| Supervisor signature | | | | | | | | | | | | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|---------------|-----------------|-------------------------|--------------------|---------------------|
| UNCUT THREAD | HELPER PROBLEM | CUT THE AD PROCESS WIRE | PM, APM, LO | 14.01.18 |
| DIRTY SPOT | HOUSE KEEPING | CLEAN HOUSE KEEPING | | |
| SKIP STITCH | MACHINE ADJUSTM | MACHINE ADJUSTM | | |

Quality Controller: [Signature]
QC-Incharge: [Signature]
Floor Incharge: [Signature]
APM/DPM: [Signature]
PM: [Signature]
QM: [Signature]

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DHU % = TU defects qty X100
TII check qty

Hourly DHU Report (At Finishing QC table)

Date: 11-03-2018
DHU AVG% 1.15%

GETUP (3)

Order No: 221448/AO-18-52 Style Name: BONNY Color: LIGHT GREY
 Floor No: UNIT-03 Line No: 17 Table Quality Name: NURUZZAMAN

Buyer :- HSM

| Defects Name | Hour | | | | | | | | | | Total |
|---------------------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | | | | | | | | | | | |
| Button/Snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut Damage | | | | | | 11 | 1 | | | | 02 |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | 1 | | | | | | | 01 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Rawedge | | | | | | | | | | | |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | | | | | | | |
| Skip stitch | | | | 1 | | | | | | | 01 |
| Shading | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up-down | | | | | | | | | | | |
| Un-even | | | | | | | | | | | |
| Uncut thread | | | 1 | | | | | | | | 01 |
| Wavyness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong Placement | | | | | | | | | | | |
| Yarn contamination | 1 | 1 | | | | | 1 | | | 1 | 04 |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Pocket | | | | | | | | | | | |
| Pleat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | | | | | |
| Dirty spot | 1 | 1 | 11 | | | 11 | 1 | 1 | | 11 | 11 |
| Rejects | | | | 1 | | 1 | | | | | 02 |
| Pressing Defect | | | | | | | | | | | |
| Losse Thread | | | | | | | | | | | |
| Poor Ironing Shape | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| Total check gmts | 240 | 210 | 180 | 150 | 140 | 220 | 200 | 220 | 170 | 260 | 1990 |
| Total Pass gmts | 240 | 210 | 180 | 149 | 140 | 219 | 200 | 220 | 170 | 260 | 1988 |
| Total defectives gmts | 02 | 02 | 03 | 03 | 00 | 06 | 02 | 01 | 00 | 03 | 22 |
| Total defects qty | 02 | 02 | 03 | 03 | 00 | 07 | 02 | 01 | 00 | 03 | 23 |
| DHU% | 0.83% | 0.95% | 1.66% | 2% | 00% | 3.18% | 1% | 0.45% | 00% | 1.15% | 1.15% |
| defectives rectified qty | 02 | 02 | 03 | 02 | 00 | 05 | 02 | 01 | 00 | 03 | 20 |
| defectives balance qty | - | - | - | - | - | - | - | - | - | - | - |
| Rectify defectives check & pass | 02 | 02 | 03 | 02 | 00 | 05 | 02 | 01 | 00 | 03 | 20 |
| Rejects qty | | | | | | | | | | | |
| Supervisor signature | | | | | | | | | | | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|------------------------|----------------------|-------------------------------|--------------------|---------------------|
| ① DIRTY SPOT - 11 | NOT USE POLY & PLATE | USE POLY & PLATE NEAT & CLEAN | S/V-L/C-Q/C | 11-03-18 |
| ② YARN CONTAMINATION-d | | | | |
| ③ CUT DAMAGE - 03 | O/P 3 H/P PROBLEM | TRAINING THE O/P H/P | S/V-L/C-Q/C | |

Quality Controller: [Signature] QC. Incharge: [Signature] Floor Incharge: [Signature] APM/DPM: [Signature] PM: [Signature] QM: [Signature]

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DHU % = (TI defects qty X 100) / TI check qty

Hourly DHU Report (At Finishing QC table)

Date: 12-08-2018
DHU AVG% 1.52%

Order No: 291448 AO-18-52 Style Name: Rony Color: Light Grey
 Floor No: U-3 Line No: 21 Table Quality Name: MORNING
 Buyer: HSM

| Defects Name | Hour | | | | | | | | | | Total |
|---------------------------------|--------------------|--------------------|--------------------|--------------------|--------------------|--------------------|--------------------|--------------------|--------------------|--------------------|-------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | | 1 | | | | | | | | 11 | 07 |
| Button/Snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut Damage | | | | | | | | | | | |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | | | | | | | | |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Rawedge | | | | | | | | | | | |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | | | | | | | |
| Skip stitch | | | | | | 1 | | | | | 01 |
| Shading | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up-down | | | | | | | | | | | |
| Un-even | | | | | | | | | | | |
| Uncut thread | | | | | | | | | | | |
| Wavyness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong Placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Pocket | | | | | | | | | | | |
| Pleat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | 1 | 11 | 1 | 11 | 06 |
| Dirty spot | 11 | 11 | 1 | 11 | 11 | | | | | | 09 |
| Rejects | | | | | | | | | | | |
| Pressing Defect | | | | | | | | | | | |
| Losse Thread | | | | | | | | | | | |
| Poor Ironing Shape | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| Total check gmts | 180 | 180 | 150 | 160 | 150 | 100 | 90 | 180 | 170 | 150 | 1510 |
| Total Pass gmts | 180 | 180 | 150 | 160 | 150 | 100 | 90 | 180 | 170 | 150 | 1510 |
| Total defectives gmts | 02 | 03 | 01 | 03 | 03 | 01 | 01 | 03 | 02 | 04 | 23 |
| Total defects qty | 02 | 03 | 01 | 03 | 03 | 01 | 01 | 03 | 02 | 04 | 23 |
| DHU% | 1.11% | 1.66% | 0.66% | 1.87% | 2% | 1% | 1.11% | 1.66% | 1.17% | 2.66% | 1.52% |
| defectives rectified qty | 02 | 03 | 01 | 03 | 03 | 01 | 01 | 03 | 02 | 04 | 23 |
| defectives balance qty | - | - | - | - | - | - | - | - | - | - | - |
| Rectify defectives check & pass | 02 | 03 | 01 | 03 | 03 | 01 | 01 | 03 | 02 | 04 | 23 |
| Rejects qty | | | | | | | | | | | |
| Supervisor signature | <i>[Signature]</i> | <i>[Signature]</i> | <i>[Signature]</i> | <i>[Signature]</i> | <i>[Signature]</i> | <i>[Signature]</i> | <i>[Signature]</i> | <i>[Signature]</i> | <i>[Signature]</i> | <i>[Signature]</i> | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|---------------|------------------------|----------------------|--------------------|---------------------|
| Dirty spot | NOT USE PROPER MACHINE | USE PROPER MACHINE | S.V. L/C. S.C | 12-08-2018 |
| Broken stitch | OPJ TRAINER PROBLEM | TRAINING OPJ TRAINER | " | " |
| Oil spot | NOT USE PROPER MACHINE | USE PROPER MACHINE | " | " |

Quality Controller: *[Signature]* QC. Incharge: *[Signature]* Floor Incharge: *[Signature]* APM/DPM: *[Signature]* PM: *[Signature]* QM: *[Signature]*

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DHU % = TI defects qty X100
TI check qty

GET-UP

Hourly DHU Report (At Finishing QC table)

Date: 13-03-18
DHU AVG% 1.43%

Order No: 289774/RO-18-233 Style Name: BOB Color: BLACK
 Floor No: UNIT-013 Line No: 17 Table Quality Name: ATIA SULTANA
 Buyer: H.B.M

| Defects Name | Hour | | | | | | | | | | Total |
|---------------------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | | | | | 1 | 1 | | | | 1 | 3 |
| Button/Snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut Damage | 11 | | | | 1 | | | | | | 3 |
| Improper tuck | | | 1 | | | | | | | | 1 |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | | | | | | 1 | | 1 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Rawedge | | | | | | | | | | | |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | | | | | | | |
| Skip stitch | | | | 1 | | | | | | | 1 |
| Shading | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up-down | | | | | | | | | | | |
| Un-even | | | | | | | | | | | |
| Uncut thread | | | | 11 | | | 1 | 11 | | | 5 |
| Wavyness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong Placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Pocket | | | | | | | | | | | |
| Pleat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | 11 | 1 | 1 | | 11 | 11 | | 11 | 11 | 12 |
| Dirty spot | | 1 | | | | | | | | | 1 |
| Rejects | | | | | | | | 1 | | | 1 |
| Pressing Defect | | | | | | | | | | | |
| Losse Thread | | | | | | | | | | | |
| Poor Ironing Shape | | | | | | | | | | | |
| Others | | 1 | | 1 | | | | | | | 2 |
| Total check gmts | 154 | 170 | 150 | 170 | 165 | 190 | 210 | 220 | 250 | 250 | 2029 |
| Total Pass gmts | 154 | 170 | 150 | 170 | 165 | 190 | 210 | 219 | 250 | 250 | 2028 |
| Total defectives gmts | 02 | 04 | 02 | 05 | 02 | 03 | 03 | 03 | 02 | 04 | 30 |
| Total defects qty | 02 | 04 | 02 | 05 | 02 | 03 | 03 | 03 | 02 | 04 | 30 |
| DHU% | 1.29% | 2.35% | 1.33% | 2.94% | 1.21% | 1.52% | 1.42% | 1.36% | 0.8% | 1.6% | 1.43% |
| defectives rectified qty | 02 | 04 | 02 | 05 | 02 | 03 | 03 | 02 | 02 | 04 | 29 |
| defectives balance qty | | | | | | | | | | | |
| Rectify defectives check & pass | 02 | 04 | 02 | 05 | 02 | 03 | 03 | 02 | 02 | 04 | 29 |
| Rejects qty | | | | | | | | | | | |
| Supervisor signature | | | | | | | | | | | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|---------------------|--------------------------|-------------------------------|--------------------|---------------------|
| 1) Oil spot - 12 | not use poly M/E problem | MIB use poly M/E. M/T | S.V. LYE. S.E | 12-03-18 |
| 2) Uncut thread - 5 | OPB MIB problem | MIB eatessally cut the thread | | |
| 3) Broken - 3 | OPB MIB problem | making OPB MIB | | |

Quality Controller: [Signature] QC. Incharge: [Signature] Floor Incharge: [Signature] APM/DPM: [Signature] PM: [Signature] QM: [Signature]

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DHU % = TII defects qty X100
TII check qty

Hourly DHU Report (At Finishing QC table)

Date: 03-03-18
DHU AVG% 4.47%

Order No: 244705 Ad No- 17-1806 Style Name: MOA Color: White
Floor No: 0-03 Line No: 17 Table Quality Name: Rabia / Sahel

Buyer: HSM

| Defects Name | Hour | | | | | | | | | | Total |
|---------------------------------|-------|-------|--------|-------|--------|-------|-------|-------|-------|-------|-------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | 11 | | | 111 | 1 | 1 | | | | | 10 |
| Button/Snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | 111 | 1 | 1 | | | 1 | 1 | 11 | | 1 | 13 |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | | | | | | | | | |
| Cut Damage | | | 1 | | | | | | | | 01 |
| Improper tuck | 1 | | | 1 | | | | | | | 02 |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | 11 | | | | 1 | | | | | 03 |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | 111 | 11 | 06 |
| Open seam | | | | 11 | 1 | | | | | | 03 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Rawedge | | | 1 | | | | | | | | 01 |
| Reverse | | | | | | | | | | | |
| Slanted | | | | | | | | | | | |
| Skip stitch | 1 | 11 | 11 | 11 | 111 | 1 | 1 | 1 | | 1 | 14 |
| Shading | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | 1 | 1 | 02 |
| Thread tension | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up-down | | | | | | | | | | | |
| Un-even | | | | | | | | | | | |
| Uncut thread | | | | | | | | | | | |
| Wavyness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong Placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| Placket | | | | | | | | | | | |
| Pocket | | | | | | | | | | | |
| Pleat | | | 1 | 11 | | 1 | 1 | | 1 | 1 | 07 |
| Side band | | | | | | | | | | | |
| Oil spot | | | | | | | | | 11 | 11 | 04 |
| Dirty spot | 10 | 25 | 27 | 22 | 26 | 10 | 15 | 14 | 15 | 14 | 200 |
| Rejects | | 11 | 1 | 111 | 11 | | | 1 | | 1 | 10 |
| Pressing Defect | | | | | | | | | | | |
| Losse Thread | | | | | | | | | | | |
| Poor Ironing Shape | | | | | | | | | | | |
| Others | | | | | | | | | | | |
| Total check gmts | 300 | 350 | 300 | 430 | 300 | 300 | 300 | 420 | 380 | 390 | 6170 |
| Total Pass gmts | 280 | 348 | 333 | 447 | 338 | 300 | 300 | 420 | 380 | 390 | 6160 |
| Total defectives gmts | 22 | 32 | 33 | 42 | 33 | 24 | 18 | 22 | 23 | 25 | 276 |
| Total defects qty | 22 | 32 | 33 | 42 | 33 | 24 | 18 | 22 | 23 | 25 | 276 |
| DHU% | 7.33% | 9.14% | 11.00% | 9.77% | 11.00% | 8.00% | 6.00% | 5.24% | 6.05% | 6.41% | 4.47% |
| defectives rectified qty | 22 | 30 | 34 | 39 | 31 | 24 | 18 | 22 | 23 | 25 | 267 |
| defectives balance qty | - | - | - | - | - | - | - | - | - | - | - |
| Rectify defectives check & pass | 22 | 30 | 34 | 39 | 31 | 24 | 18 | 22 | 23 | 25 | 267 |
| Rejects qty | | | | | | | | | | | |
| Supervisor signature | | | | | | | | | | | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|-----------------------|----------------|----------------|--------------------|---------------------|
| 1) Dirty spot (200) | use poly s/met | MBUSC Poly s/m | M/S J. L. C. P. | 4.03.18 |
| 2) Skip stitch (10) | m/c Needle | m/c m/s Needle | S. M. T. L. C. | 11 |
| 3) Broken stitch (10) | OPPS | OPPS | U. S. V. G. C. | 10 |

Quality Controller: [Signature] QC. Incharge: [Signature] Floor Incharge: [Signature] APM/DPM: [Signature] PM: [Signature] QM: [Signature]

Amantex Limited
 Bolragirchala, Sreepur, Gazipur
Hourly DHU Report (At Sewing QC table)

DHU % = $\frac{\text{TI defects qty} \times 100}{\text{TI check qty}}$
 Date: 22.10.2017
 DHU AVG% 5.27%

①
 AO: 12-1073

Order No: 21700Z Style Name: LIMA Color: PINK
 Floor No: UN17-03 Line No: 08 Table Quality Name: SALIMA/SALMA
 Buyer: HSTM

| Defects Name | Hour | | | | | | | | | | Total |
|---------------------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | 08-09 | 09-10 | 10-11 | 11-12 | 12-01 | 02-03 | 03-04 | 04-05 | 05-06 | 06-07 | |
| Broken stitch | | 1 | | 11 | | | | | | | 04 |
| Button/Snap/Adjustable | | | | | | | | | | | |
| Button hole | | | | | | | | | | | |
| Fabric fault | | | | | | | | | | | |
| Drop stitch | | | | | | | | | | | |
| Needle hole | | | 1 | | | | | | | | 01 |
| Cut Damage | | 1 | | | | | | | | | 01 |
| Improper tuck | | | | | | | | | | | |
| Improper shape | | | | | | | | | | | |
| Joint stitch | | | | | | | | | | | |
| Label fault | | | | | | | | | | | |
| Needle mark | | | | | | | | | | | |
| Open seam | | | | 1 | | | | | | | 01 |
| Print fault | | | | | | | | | | | |
| Embroidery | | | | | | | | | | | |
| Puckering | | | | | | | | | | | |
| Rawedge | | 11 | | 1 | | | | | | | 03 |
| Reverse | | | | | | | | | | | |
| Skipped | | | | | | | | | | | |
| Skip stitch | | | | | 11 | | | | | | 02 |
| Shading | | | | | | | | | | | |
| Stripe Not Match | | | | | | | | | | | |
| Thread mistake | | | | | | | | | | | |
| Twisting | | | | | | | | | | | |
| Thread tension | | | | | | | | | | | |
| Measurement Deviation(+) | | | | | | | | | | | |
| Measurement Deviation(-) | | | | | | | | | | | |
| Up-down | | | | | | | | | | | |
| Un-even | | | | | | | | | | | |
| Uncut thread | 111 | | 111 | | | | | | | | 06 |
| Wavyness | | | | | | | | | | | |
| Wrong SPI | | | | | | | | | | | |
| Label wrong Placement | | | | | | | | | | | |
| Yarn contamination | | | | | | | | | | | |
| Collar | | | | | | | | | | | |
| ..acket | | | | | | | | | | | |
| Pocket | | | | | | | | | | | |
| Pleat | | | | | | | | | | | |
| Side band | | | | | | | | | | | |
| Oil spot | | | 11 | 11 | 1 | | | | | | 05 |
| Dirty spot | | | | | | | | | | | |
| Rejects | | | | 1 | | | | | | | 01 |
| Others | | | | | | | | | | | |
| Total check gmts | 65 | 100 | 100 | 105 | 85 | | | | | | 455 |
| Total Pass gmts | 65 | 100 | 100 | 104 | 85 | | | | | | 454 |
| Total defectives gmts | 03 | 04 | 04 | 05 | 03 | | | | | | 19 |
| Total defects qty | 03 | 05 | 06 | 07 | 03 | | | | | | 24 |
| DHU% | 4.61 | 5% | 6% | 6.67 | 3.52 | | | | | | 5.27% |
| defectives rectified qty | 03 | 05 | 04 | 05 | 03 | | | | | | 19 |
| defectives balance qty | - | - | - | - | - | | | | | | - |
| Rectify defectives check & pass | 03 | 05 | 04 | 05 | 03 | | | | | | 19 |
| Rejects qty | | | | | | | | | | | |
| Supervisor signature | | | | | | | | | | | |

| TOP 3 defects | Root Cause | CAP | Responsible Person | Implementation Date |
|------------------|-------------------|------------------|--------------------|---------------------|
| uncut thread - 6 | carbons helpax | Training helpax | JNC/APM | 23-10-17 |
| oil spot - 5 | Machining Problem | Machining Seivyn | Machmetad | 23-10-17 |
| broken - 4 | carbons helpax | Training helpax | Training helpax | 23-10-17 |

Quality Controller QC.Incharge Floor Incharge APM/DPM PM OM

BEATS FASHION LTD.

East Chandora, Shaifpur, Kalkaikoil, Gazipur

End Line Inspection Report

Section : Sewing

Date: 14-03-2018

Factory: BEATS FASHION LTD.

Line No: N-12

Inspector: SHANOUR

Alter Pcs x 100 = %

Total Pcs

| Item | B | BB | BBB | D | DT | E | F | G | HP | HW | IS | IM | L | LS | M | N | NS | O | OP | OV | P | R | RE | RI | S | SK | SP | T | TT | TTT | TH | U | UP | UE | UW | V | W | WM | WS | Visible Edge |
|------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|---------|---|----|---|---|----|---|----|----|---|---|----|----|---|----|----|---|----|-----|----|---|----|----|----|---|---|----|----|--------------|
| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Total Received | 100 | 100 | 100 | 100 | 100 | 100 | 100 | 100 | 100 | 100 | 100 | 100 | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Ok | 96 | 96 | 96 | 96 | 96 | 96 | 96 | 96 | 96 | 96 | 96 | 3.57% | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Alter | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 3.57% | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Alter Rectified | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | 3.57% | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Total Ok | 100 | 100 | 100 | 100 | 100 | 100 | 100 | 100 | 100 | 100 | 100 | 0.63% | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| REMARKS | BR-1 | LS-11 | LS-11 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | 1.00% | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| NECK | LS-11 | LS-11 | LS-11 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | 0.39% | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| MOUTH | LS-11 | LS-11 | LS-11 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | 0.39% | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| HEM | DS-1 | DS-1 | DS-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | 0.39% | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| WST/AM | TL-1 | TL-1 | TL-1 | SK-1 | SK-1 | SK-1 | SK-1 | SK-1 | SK-1 | SK-1 | SK-1 | 0.23% | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| SIDE 7/5 | DS-1 | DS-1 | DS-1 | OP-11 | OP-11 | OP-11 | OP-11 | OP-11 | OP-11 | OP-11 | OP-11 | 0.31% | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| WAIST | TL-1 | TL-1 | TL-1 | OP-11 | OP-11 | OP-11 | OP-11 | OP-11 | OP-11 | OP-11 | OP-11 | 0.15% | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| BACK P: | TL-1 | TL-1 | TL-1 | TL-1 | TL-1 | TL-1 | TL-1 | TL-1 | TL-1 | TL-1 | TL-1 | 0.23% | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| FRONT P: | LS-1 | LS-1 | LS-1 | LS-1 | LS-1 | LS-1 | LS-1 | LS-1 | LS-1 | LS-1 | LS-1 | 0.15% | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| L/Chief Sing | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Chief Controller | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Floor Chief

P.M

Q.M

BEATS FASHION LTD.

East Chandora, Shafipur, Kalkaoti, Gazipur

End Line Inspection Report

Section : Sewing

Date: 15-03-2018
 Factory: BEATS FASHION LTD.
 Line No: N-12
 Inspector: SHARON
 Alter Pcs x 100 = %
 N.P. Total Pcs

| | | | | | | | | | | | | | |
|------|-------|--------|---------|--------|------|---------------|------------|------------------|---------------|-----------|------------|----------------|--------------|
| Item | Agent | Buyer | Style | PO/Art | Item | Broken Stitch | Embroidery | Incomplete Stich | Needle Mark | Puckering | Skip Stich | Thread Mistake | Visible Edge |
| | AB A | J VLES | 3112.86 | 325460 | B | F | IM | NS | Narrow Stich | R | SP | Uneven Stich | W |
| | | | | | BB | G | L | O | Oil Mark | RE | T | Uneven Point | WM |
| | | | | | D | HP | LS | OP | Loop Started | RJ | TT | Uneven Lobe | WS |
| | | | | | DT | HW | M | OV | Missing Stich | S | TL | Uneven Width | Down Stich |
| | | | | | | | | | | | | | |

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|------------------|-------|------|-------|-------|-------|-------|-------|-------|-------|-------|-------|---------|
| Total Received | 100 | 100 | 100 | 110 | 120 | 110 | 120 | 120 | 120 | 140 | 1140 | |
| OK | 96 | 96 | 95 | 106 | 119 | 103 | 115 | 119 | 115 | 135 | 1086 | |
| Alter | 4 | 4 | 5 | 4 | 4 | 4 | 5 | 4 | 5 | 5 | 44 | 3.84% |
| Alter Rectified | 4 | 4 | 5 | 4 | 4 | 4 | 5 | 4 | 5 | 5 | 44 | 3.84% |
| Total Ok | 100 | 100 | 100 | 110 | 120 | 110 | 120 | 120 | 120 | 140 | 1140 | |
| BACKLACK | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | 9 | 0.78% |
| LOOP | LS-11 | DS-1 | LS-11 | LS-11 | LS-11 | LS-11 | LS-11 | LS-11 | LS-11 | LS-11 | 12 | 1.05% |
| NEUTH | DS-1 | DS-1 | UL-1 | UL-1 | DS-11 | UL-11 | UL-11 | DS-11 | UL-11 | UL-11 | 6 | 0.52% |
| HEM | UL-1 | UL-1 | UL-1 | UL-1 | UL-1 | UL-1 | UL-1 | UL-1 | UL-1 | UL-1 | 8 | 0.70% |
| INSEAM | | | | | | | | | | | 2 | 0.17% |
| SIDE T/S | | OP-1 | | | | | DS-1 | | | | 2 | 0.17% |
| YAKST | | | | | | | | | | | | |
| BACK P. | | | | | OV-1 | | | | | | 3 | 0.26% |
| FRONT P. | | | | | | | | | | | 2 | 0.17% |
| L/Chief Sing | | | | | | LS-1 | | | | | | |
| Chief Controller | | | | | | | | | | | | |

Floor Chief

P.M

Q.M

BEATS FASHION LTD.

East Chandora, Shalipur, Kalikoilr, Gazipur

End Line Inspection Report

Section : Sewing

Date: 12-09-18
 Factory: BEATS FASHION LTD.
 Line No: N-12
 Inspector: SHANOUR
 Alter Pcs x 100 = %
 N.B. Total Pcs

Agent: M.B.A
 Buyer: JULES
 Style: 11266
 PO/Art: 325460
 Item: SHORT PANT

| | | | | | | | | | | | | | | | |
|----|------------------|----|----------------|----|------------------|----|--------------|----|---------------|----|----------------|----|--------------|----|--------------|
| B | Broken Stitch | E | Embroidery | IM | Incomplete Stich | N | Needle Mark | P | Puckering | SK | Skip Stich | TH | read Mistake | V | Visible Edge |
| BR | Bubbling | F | Fabric Full | LM | Label Mistake | NS | Narrow Stich | R | Run off Stich | SP | Started Pucker | U | even Stich | W | Weavy Zipper |
| BR | Bar Tack missing | G | Gathering | L | Loop Stanted | O | Oil Mark | RE | Raw Edge | T | Twisted | UP | even Point | WM | Wavy Mistake |
| D | Damage | HP | High Low PRT | CS | Missing Stich | OP | Open Stich | RJ | Reject | TT | Tension Tight | UD | even Loh | WS | Wide Stich |
| DT | Dirty | HW | High Low Waist | M | Over Stich | OV | Over Stich | S | Shading | TL | Tension Loose | UW | even Width | DS | Down Stich |

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|---------|
| Total Received | 100 | 110 | 120 | 110 | 100 | 110 | 120 | 120 | 110 | 130 | 1130 | |
| Ok | 95 | 105 | 119 | 105 | 96 | 105 | 110 | 115 | 105 | 125 | 1130 | |
| Alter | 5 | 5 | 1 | 5 | 4 | 5 | 9 | 5 | 5 | 5 | 47 | 4-15% |
| Alter Rectified | 5 | 5 | 1 | 5 | 4 | 5 | 9 | 5 | 5 | 5 | 47 | 4-15% |
| Total Ok | 100 | 110 | 120 | 110 | 100 | 110 | 120 | 120 | 110 | 130 | 1130 | |
| ALTER/ACK | BR-1 | BR-1 | LS-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | LS-11 | BR-1 | BR-1 | 0-53% |
| 100% | LS-11 | LS-1 | LS-1 | LS-11 | LS-11 | LS-11 | LS-11 | LS-11 | LS-11 | LS-1 | LS-1 | 0-26% |
| 100% | DS-1 | DS-1 | DS-1 | DS-1 | DS-1 | DS-1 | DS-1 | DS-1 | DS-1 | DS-1 | DS-1 | 0-35% |
| 100% | UC-1 | UC-1 | UC-1 | UC-1 | UC-1 | UC-1 | UC-1 | UC-1 | UC-1 | UC-1 | UC-1 | 0-30% |
| 100% | TL-11 | TL-11 | TL-11 | TL-11 | TL-11 | TL-11 | TL-11 | TL-11 | TL-11 | TL-11 | TL-11 | 0-35% |
| 100% | SM-11 | SM-11 | SM-11 | SM-11 | SM-11 | SM-11 | SM-11 | SM-11 | SM-11 | SM-11 | SM-11 | 0-17% |
| 100% | OV-1 | OV-1 | OV-1 | OV-1 | OV-1 | OV-1 | OV-1 | OV-1 | OV-1 | OV-1 | OV-1 | 0-44% |
| 100% | FRONT | FRONT | FRONT | FRONT | FRONT | FRONT | FRONT | FRONT | FRONT | FRONT | FRONT | 0-17% |
| L/Chief Sing | | | | | | | | | | | | |
| Chief Controller | | | | | | | | | | | | |

Floor Chief

PM

QM

BEATS FASHION LTD.

East Chandora, Shafipur, Kalikotr, Gazipur

In Process Inspection Report

Section : Finishing

Agent : ABA
 Buyer : JULES
 Style : 7112-66
 PO/Art : 325460
 ST : SHORT PANT
 CC

Date : 13-03-2012
 Factory : BEATS FASHION LTD.
 Line No : N-12
 Inspector : SHANOUR
 N.I. : Alter Pes x 100 = %
 Total Pes

| Description | Process | | | | | | | | | | Total | Remarks | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--|---------|------|------|-------|------|-------|-------|------|------|-------|-----------|---------|---------|---|---|---|---|---|---|---|---|---|----|-----------|---------|----------|------|------|------|------|------|------|-------|------|------|------|----|-------|------|-------|------|------|------|------|------|------|------|------|-------|---|-------|-------|-------|------|------|------|------|-------|--|--|--|--|----|-------|---------|--|--|------|--|--|--|--|--|--|--|---|-------|---------|-------|--|--|--|--|--|--|--|--|--|---|-------|------|--|--|--|--|--|--|--|--|--|--|---|-------|---------|--|--|------|-------|------|--|------|--|--|--|---|-------|---------|--|--|--|--|------|--|--|--|--|--|---|-------|
| | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Total Received | 100 | 110 | 120 | 110 | 120 | 110 | 120 | 110 | 120 | 110 | 1190 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Ok | 95 | 105 | 115 | 105 | 115 | 105 | 115 | 105 | 115 | 105 | 1130 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Alter | 5 | 5 | 5 | 5 | 5 | 5 | 5 | 5 | 5 | 5 | 46 | 4.07% | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Alter Rectified | 5 | 5 | 5 | 4 | 5 | 4 | 5 | 4 | 5 | 4 | 46 | 4.07% | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Total Ok | 100 | 110 | 120 | 110 | 120 | 110 | 120 | 110 | 120 | 110 | 1190 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <table border="1"> <thead> <tr> <th>Process</th> <th>1</th> <th>2</th> <th>3</th> <th>4</th> <th>5</th> <th>6</th> <th>7</th> <th>8</th> <th>9</th> <th>10</th> <th>Alter Pes</th> <th>Remarks</th> </tr> </thead> <tbody> <tr> <td>BAR TACK</td> <td>BR-1</td> <td>LS-1</td> <td>BR-1</td> <td>BR-1</td> <td>LS-1</td> <td>BR-1</td> <td>LS-11</td> <td>BR-1</td> <td>LS-1</td> <td>BR-1</td> <td>10</td> <td>0.83%</td> </tr> <tr> <td>LOOP</td> <td>BS-11</td> <td>LS-1</td> <td>BS-1</td> <td>DS-1</td> <td>LS-1</td> <td>BS-1</td> <td>TL-1</td> <td>LS-1</td> <td>BS-1</td> <td>LS-11</td> <td>7</td> <td>0.61%</td> </tr> <tr> <td>WORTH</td> <td>UL-11</td> <td>UL-1</td> <td>UL-1</td> <td>UL-1</td> <td>UL-1</td> <td>SK-11</td> <td></td> <td></td> <td></td> <td></td> <td>10</td> <td>0.83%</td> </tr> <tr> <td>WASHING</td> <td></td> <td></td> <td>SK-1</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>2</td> <td>0.17%</td> </tr> <tr> <td>TOP FUS</td> <td>TL-11</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>3</td> <td>0.26%</td> </tr> <tr> <td>WASH</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>1</td> <td>0.08%</td> </tr> <tr> <td>IRONING</td> <td></td> <td></td> <td>OV-1</td> <td>OV-11</td> <td>OV-1</td> <td></td> <td>SK-1</td> <td></td> <td></td> <td></td> <td>5</td> <td>0.42%</td> </tr> <tr> <td>PACKING</td> <td></td> <td></td> <td></td> <td></td> <td>15-1</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>4</td> <td>0.35%</td> </tr> </tbody> </table> | | | | | | | | | | | | | Process | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Alter Pes | Remarks | BAR TACK | BR-1 | LS-1 | BR-1 | BR-1 | LS-1 | BR-1 | LS-11 | BR-1 | LS-1 | BR-1 | 10 | 0.83% | LOOP | BS-11 | LS-1 | BS-1 | DS-1 | LS-1 | BS-1 | TL-1 | LS-1 | BS-1 | LS-11 | 7 | 0.61% | WORTH | UL-11 | UL-1 | UL-1 | UL-1 | UL-1 | SK-11 | | | | | 10 | 0.83% | WASHING | | | SK-1 | | | | | | | | 2 | 0.17% | TOP FUS | TL-11 | | | | | | | | | | 3 | 0.26% | WASH | | | | | | | | | | | 1 | 0.08% | IRONING | | | OV-1 | OV-11 | OV-1 | | SK-1 | | | | 5 | 0.42% | PACKING | | | | | 15-1 | | | | | | 4 | 0.35% |
| Process | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Alter Pes | Remarks | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| BAR TACK | BR-1 | LS-1 | BR-1 | BR-1 | LS-1 | BR-1 | LS-11 | BR-1 | LS-1 | BR-1 | 10 | 0.83% | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| LOOP | BS-11 | LS-1 | BS-1 | DS-1 | LS-1 | BS-1 | TL-1 | LS-1 | BS-1 | LS-11 | 7 | 0.61% | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| WORTH | UL-11 | UL-1 | UL-1 | UL-1 | UL-1 | SK-11 | | | | | 10 | 0.83% | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| WASHING | | | SK-1 | | | | | | | | 2 | 0.17% | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| TOP FUS | TL-11 | | | | | | | | | | 3 | 0.26% | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| WASH | | | | | | | | | | | 1 | 0.08% | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| IRONING | | | OV-1 | OV-11 | OV-1 | | SK-1 | | | | 5 | 0.42% | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| PACKING | | | | | 15-1 | | | | | | 4 | 0.35% | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Floor Chief

P.M

Q.M

BEATS FASHION LTD.

East Chandora, Sharnpur, Kailashpur, Gazipur

In Process Inspection Report

Section : Finishing

Agent : ABN
 Buyer : JULES
 Style : 411266
 PO/Art : 325958
 Item : SHORT PANTS

Date : 20-08-2012
 Factory : BEATS FASHION LTD.
 Line No : IV-12
 Inspector : SHANOOK
 N.B. : Alter Pcs x 100 = %
 Total Pcs : _____

| | | | | | | | | | | | | | | | |
|----|------------------|----|----------------|----|------------------|----|--------------|----|---------------|----|---------------|----|----------------|----|--------------|
| B | Broken Stitch | E | Embroidery | IS | Incomplete Stich | N | Needle Mark | P | Puckering | ST | Slip Stich | TH | Thread Mistake | V | Visible Edge |
| BB | Bubbling | F | Fabric Fault | IM | Ink Mark | NS | Narrow Stich | R | Run off Stich | SP | Spined Pocket | U | Uneven Stich | W | Wavy Zipper |
| BR | Bar Tack missing | G | Gathering | I | Label Mistake | O | OH Mark | RE | Raw Edge | T | Twisted | UP | Uneven Point | WM | Wavy Mistake |
| D | Damage | HP | High Low PKT | LS | Loop Stained | OP | Open Stich | RJ | Reject | TT | Tension Tight | UW | Uneven Lob | WS | Wide Stich |
| DT | Dirty | HW | High Low Waist | M | Missing Stich | OS | Over Stich | S | Shading | TD | Tension Loose | | | | |

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|--------------------|----------|-------|------|-------|------|-------|------|-------|-------|------|-------|---------|
| Total Received | 100 | 110 | 110 | 120 | 120 | 100 | 120 | 100 | 110 | 100 | 1090 | |
| Alter | 95 | 95 | 100 | 105 | 95 | 95 | 115 | 95 | 105 | 95 | 47 | 4.31% |
| Alter Rectified | 5 | 4 | 5 | 5 | 4 | 5 | 5 | 5 | 4 | 5 | 47 | 4.31% |
| Total Ok | 100 | 110 | 110 | 120 | 120 | 100 | 120 | 100 | 110 | 100 | 1090 | |
| Process | BAR TACK | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | BR-1 | 6 | 0.55% |
| | LOOP | LS-11 | LS-1 | LS-11 | LS-1 | LS-11 | LS-1 | LS-1 | LS-11 | LS-1 | 71 | 1.00% |
| | POCKET | DS-1 | DS-1 | DS-1 | DS-1 | DS-1 | DS-1 | DS-1 | DS-1 | DS-1 | 9 | 0.82% |
| | HEM | VL-1 | VL-1 | VL-1 | VL-1 | VL-1 | VL-1 | VL-1 | VL-1 | VL-1 | 8 | 0.73% |
| | HEM 7/5 | | 7L-1 | | OP-1 | DS-1 | | 7L-11 | VL-1 | | 1 | 0.09% |
| | HEM 7/5 | | | | | | | | | | 3 | 0.27% |
| | HEM 7/5 | | | | | | | | | | 2 | 0.18% |
| | HEM 7/5 | | | | | | | | | | 4 | 0.36% |
| | HEM 7/5 | | | | | | | | | | 3 | 0.27% |
| Finishing Incharge | | | | | | | | | | | | |
| Controller | | | | | | | | | | | | |

Floor Chief

P.M

Q.M

B.L. TS FASHION I, TD.

East Chandora, Shaipur, Kaliahor, Gazipur

In Process Inspection Report

Section : Finishing

Date: Apr 03, 2018
 Factory: B.L.F.I.
 Line No: 1111
 Inspector: K.V.U
 Alter Pes: 100
 Total Pes: 951

| | | | | | | | | | | | | | |
|----------------|-----|------------|----|-------------------|-----|---------------|----|---------------|----|----------------|----|----------------|-----|
| Broken Stitch | E | Embroid 57 | TS | Incomplete Stitch | N | Needle Mark | P | Packering | SK | Skip Stitch | TH | Thread Mistake | V |
| Rolling | F | Fabric 78 | TM | Ind Mark | NNS | Narrow Stitch | R | Rem of Stitch | SR | Slanted Pocket | U | Threen Stitch | YV |
| For Tear minge | G | Cadbery | L | Loop Mistake | O | Oil Mark | RT | Rear Edge | T | Twisted | UP | Threen Point | W/M |
| Therose | HP | High L | IS | Loop Started | OP | Open Stich | RP | Repect | TT | Tension Tight | UL | Threen Lob | W/S |
| HTV | HTV | High L/W | M | Missing Stich | OT | Over Stich | S | Shading | TL | Tension Loose | UV | Threen Width | W/S |

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total |
|--------------------|------|------|------|------|------|------|------|------|------|------|-------|
| Total Received | 643 | 659 | 663 | 669 | 670 | 673 | 675 | 677 | 679 | 681 | 4165 |
| OK | 600 | 600 | 600 | 600 | 600 | 600 | 600 | 600 | 600 | 600 | 4070 |
| Alter | 43 | 40 | 40 | 40 | 40 | 44 | 45 | 40 | 40 | 40 | 425 |
| Alter Rectified | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 220 |
| Total OK | 610 | 620 | 620 | 620 | 620 | 620 | 620 | 620 | 620 | 620 | 4290 |
| WAST | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 85 |
| Front Panel | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | 101 |
| Satidation | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | 44 |
| TRISCOM | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | 20 |
| Back Panel | B-10 | SK-5 | B-10 | SK-5 | B-10 | SK-5 | B-10 | SK-5 | B-10 | SK-5 | 104 |
| Back Panel | B-10 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | 48 |
| Finishing Incharge | | | | | | | | | | | |
| Controller | | | | | | | | | | | |

SK-124
 B-220
 B-30

Floor Chief

P.M

Q.M

Agent: BEATS FASHION LTD
 Buyer: TALENT
 Style: FORTN SVGT
 PO/Art: LADIES SWEAT

East Chandora, Shafipur, Kailashpur, Gazipur
In Process Inspection Report

Section : Finishing

Date: 15.03.2018
 Factory: B.P.L
 Line No: 1011
 Inspector: Talim
 Alter Pes: 100
 N.B. Total Pes = 9.59%

| Description | Broken Stich | | Embroidery | | Incomplete Stich | | Needle Mark | | Puckering | | Skipped Stich | | Thread Mistake | | Visible Edge | | |
|--------------------|------------------|---------|--------------|--------------|------------------|--------------|---------------|------------|-----------|-------|---------------|----------------|----------------|--------------|--------------|------------|-------|
| | BR | BP | F | IM | IS | IM | N | NS | R | RE | SP | S | TH | U | V | W | |
| | Bar Tack missing | Package | High Low PRT | High Low Wat | Label Mistake | Loop Started | Missing Stich | Over Stich | Raw Edge | Irreg | Twisted | Skipped Pocket | Twisted | Uneven Point | Uneven Lab | Wide Stich | |
| | HP | HP | High Low PRT | High Low Wat | IS | Loop Started | Missing Stich | Over Stich | Raw Edge | Irreg | Twisted | Skipped Pocket | Twisted | Uneven Point | Uneven Lab | Wide Stich | |
| Total Received | 690 | 690 | 910 | 910 | 685 | 9015 | 550 | 156 | 260 | 560 | 4945 | 550 | 580 | 451 | 550 | 451 | 550 |
| OK | 590 | 590 | 690 | 690 | 600 | 810 | 500 | 15 | 200 | 500 | 4510 | 520 | 510 | 450 | 400 | 490 | 490 |
| Alter | 90 | 90 | 90 | 90 | 85 | 905 | 50 | 255 | 60 | 95 | 60 | 95 | 60 | 95 | 60 | 95 | 60 |
| Alter Rectified | 90 | 90 | 90 | 90 | 85 | 905 | 50 | 255 | 60 | 95 | 60 | 95 | 60 | 95 | 60 | 95 | 60 |
| Total OK | 500 | 500 | 600 | 600 | 515 | 720 | 450 | 145 | 140 | 410 | 410 | 410 | 410 | 410 | 410 | 410 | 410 |
| WAFST | SK-10 | B-11 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 |
| Front Panel | B-10 | B-11 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 |
| Salesman | SK-5 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 |
| Insiam | SK-10 | D-3 | SK-10 | B-5 | SK-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 |
| Rack Panel | B-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 | SK-10 |
| Bottom | B-10 | SK-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 |
| Finishing Incharge | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar |
| Controller | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar | Agar |

Remarks: 9.59%

SK = 280
 B = 201
 D = 11

Floor Chief

P.M

Q.M

BE TS FASHION L.D.

East Chandora, Shalpur, Kalikoif, Gazipur

In Process Inspection Report

Section : Finishing

Agent: BEATS FASHION LTD
 Buyer: TRIDENT
 Style: E320
 CO/ART: LADIES L/TANK
 Item:

Date: 17.03.2018
 Factory: B.F.L
 Line No:
 Inspector: Jaily
 Alter Pcs: 100
 N.B. Total Pcs = 9156

| | | | | | | | | | | | | | | |
|-----------------|-----|--------------|----|------------------|----|--------------|----|---------------|----|----------------|-----|---------------|----|--------------|
| Broken Stitch | E | Embroidery | IS | Incomplete Stich | N | Needle Mark | P | Puckering | SK | Slap Stich | TH | Thread Misale | V | Visible Edge |
| Cobbine | F | Fabric Fath | IM | Ink Mark | NS | Narrow Stich | R | Raw off Stich | SP | Staired Pucker | TI | Unopen Stich | W | Wavy Zipper |
| Raw Tord mching | G | Gathering | L | Label Misale | O | OH Mark | RE | Raw Edge | T | Twisted | TI | Unopen Point | WM | Wan Misale |
| Parance | HP | High low PK? | LS | Loop Started | OP | Open Stich | RT | Reject | TT | Tension Tight | TI | Unopen Lobb | WS | Wide Stich |
| High low Mat | HIV | High low Mat | M | Mising Stich | OV | Over Stich | S | Shading | TL | Tension Loose | TIW | Uncon Width | WS | Wide Stich |

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|--------------------|-------|------|------|-------|------|------|------|------|------|-------|-------|---------|
| Total Received | 945 | 445 | 400 | 415 | 470 | 485 | 490 | 545 | 545 | 540 | 4644 | |
| OK | 920 | 450 | 410 | 400 | 450 | 450 | 500 | 400 | 490 | 490 | 4200 | |
| Alter | 25 | 45 | 40 | 45 | 50 | 45 | 45 | 45 | 45 | 45 | 444 | |
| Alter Rectified | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 100 | |
| Total OK | 910 | 440 | 400 | 390 | 440 | 440 | 490 | 390 | 480 | 480 | 4100 | |
| WAIST | B-6 | B-5 | SK-5 | B-5 | B-3 | SK-3 | B-3 | B-3 | SK-5 | B-5 | 4440 | |
| FRONT PART | SK-10 | SK-5 | SK-5 | SK-10 | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-10 | 4440 | |
| SARDESKAN | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-10 | 4440 | |
| INSIOM | SK-3 | SK-2 | SK-5 | SK-3 | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-10 | 4440 | |
| BACK PART | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | 4440 | |
| Bottom | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | 4440 | |
| Finishing Incharge | SK-10 | SK-5 | SK-5 | SK-10 | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-10 | 4440 | |
| Controller | SK-10 | SK-5 | SK-5 | SK-10 | SK-5 | SK-5 | SK-5 | SK-5 | SK-5 | SK-10 | 4440 | |

SK-10
 SK-5
 SK-5
 SK-10
 SK-5
 SK-5
 SK-10
 SK-5
 SK-5
 SK-10
 SK-5
 SK-5
 SK-10

Floor Chief

P.M

Q.M

BEA TS FASHION LTD.

E Chandora, Shaifpur, Kalkatfir, Gazip 9r

Agent: BEA TS FASHION LTD
 Buyer: THE PRIMA
 Style: LACIEN
 PO/Art: L-015 V-0475

In Process Inspection Report

Section : Finishing

Date: 18.03.2018
 Factory: B.F.L
 Line No: 10114
 Inspector: Kalliy
 Alter Pes 100
 N.B. Total Pes 12121.

| Defect | Broken Stitch | E | Embroidery | IS | Incomplete Stich | N | Needle Mark | P | PK | SK | Ship Stich | TH | V | Visible Edge |
|--------|------------------|----|---------------|----|------------------|----|--------------|----|---------|----|---------------|----|-----|---------------|
| Code | Wobbling | F | Fabric Fall | IM | Ink Mark | NS | Narrow Stich | R | RE | RP | Raw off Stich | U | W | Wavy Zipper |
| Code | Bar Tick missing | G | Garboring | L | Label Mismatch | OS | OB Mark | RF | RF | RT | Repet | T | WNI | Wavy Mismatch |
| Code | Barcode | HP | High Low Pkt | TS | Loon Shared | OS | Open Stich | RD | RD | TL | Tension Tight | UL | WNI | Wavy Mismatch |
| Code | MT Defect | HW | High Low Vari | M | Misling Stich | S | Over Stich | S | Shading | TL | Tension Loose | UW | WNI | Wavy Mismatch |

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | Remarks |
|--------------------|------|------|------|------|------|------|------|------|------|------|-------|---------|
| Total Received | 966 | 155 | 455 | 29 | 125 | 110 | 101 | 130 | 116 | 116 | 9288 | 12.21% |
| OK | 900 | 180 | 400 | 25 | 130 | 180 | 130 | 130 | 100 | 100 | 9290 | |
| Alter | 66 | 75 | 55 | 4 | 45 | 30 | 45 | 40 | 16 | 15 | 418 | |
| Alter Rectified | 20 | 40 | 20 | 20 | 10 | 10 | 10 | 10 | 10 | 10 | 210 | |
| Total OK | 1390 | 190 | 420 | 20 | 120 | 190 | 140 | 140 | 110 | 110 | 9500 | |
| WALSH | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | | |
| Front Panel | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | | |
| Sleeve | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | | |
| INSI | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | | |
| Back Panel | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | | |
| Bottom | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | | |
| Finishing Incharge | | | | | | | | | | | | |
| Controller | | | | | | | | | | | | |

Floor Chief

PM

QM

SK = 152
 B = 187
 P = 148
 O = 31

BEA TS FASHION LTD.

East Chandora, Shaifpur, Kalikoif, Gazipur

BEA TS FASHION LTD.
 Buyer: OKAIDI
 Style: 83445
 PO/Art: Ladies 1/1000

In Process Inspection Report

Section : Finishing

Date: 02.02.2018
 Factory: S.F.1
 Line No: 1011
 Inspector: L.M.
 Alter Pcs: 100 = % 9.531
 Total Pcs

| Description | Process | | | | | | | | | | Total | Remarks |
|--------------------|-------------|------|------|------|------|------|------|------|------|------|-------|---------|
| | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | | |
| Total Received | 235 | 235 | 235 | 235 | 235 | 235 | 235 | 235 | 235 | 235 | 2664 | |
| OK | 200 | 200 | 200 | 200 | 200 | 200 | 200 | 200 | 200 | 200 | 2400 | |
| Alter | 35 | 35 | 35 | 35 | 35 | 35 | 35 | 35 | 35 | 35 | 264 | |
| Alter Rectified | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 130 | |
| Total Ok | 210 | 210 | 210 | 210 | 210 | 210 | 210 | 210 | 210 | 210 | 2530 | |
| MAJST | B-6 | B-6 | B-6 | B-6 | B-6 | B-6 | B-6 | B-6 | B-6 | B-6 | | |
| Front Panel | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | | |
| Sideseam | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | | |
| INSIAM | SK-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | B-5 | | |
| Back Panel | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | B-10 | | |
| Bottom | B-2 | B-2 | B-2 | B-2 | B-2 | B-2 | B-2 | B-2 | B-2 | B-2 | | |
| Finishing Incharge | [Signature] | | | | | | | | | | | |
| Controller | [Signature] | | | | | | | | | | | |

Floor Chief

P.M

Q.M

SK = 89
 B = 95
 D = 27

BEATS FASHION L

East Chandora, Shaktipur, Kallikoti, Gazipur

In Process Inspection Report

Section : Finishing

Agent : BEATS FASHION LTD
 Buyer : Mrs. Madik
 Style : ~~Beats~~ 2602
 PO/Art : ~~WKS~~ 34015

Date : 01.03.2018
 Factory : B.F.L
 Line No :
 Inspector : Lilly
 N.B. Alter Pcs 1100
 Total Pcs 8621

| | | | | | | | | | | | | | | |
|------------------|-----|--------------|----|------------------|----|--------------|----|--------------|----|---------------|-----|----------------|----|--------------|
| Broken Stitch | E | Emb. entry | IS | Incomplete Stich | N | Needle Mark | P | Puckering | SK | Ship Stich | TH | Thread Mistake | V | Visible Edge |
| Bubbling | F | Emb. Font | IM | Int. Mark | NS | Narrow Stich | R | Run of Stich | SP | Shaped Pocket | TI | Unseen Stich | W | Wavy Zipper |
| Bar Lock misfire | G | Emb. size | I | Label Mistake | O | OH Mark | RT | Run Edge | F | Tiskid | TIP | Unseen Point | WM | Wrinkle |
| Damage | HP | High on PRT | IS | Loop Stich | OV | Open Stich | RI | Reifed | TL | Tension Tight | TL | Unseen Tail | WS | Wrinkle |
| HTI | HTW | High on Wash | MT | Misfire Stich | OV | Over Stich | S | Shading | TL | Tension Loose | TW | Unseen Yarn H | WS | Wrinkle |

| Description | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | Total | REMARKS |
|--------------------|------|------|------|------|------|------|------|------|------|------|-------|---------|
| Total Received | 180 | 450 | 450 | 450 | 450 | 450 | 450 | 450 | 450 | 450 | 3954 | 8621 |
| OK | 180 | 450 | 450 | 450 | 450 | 450 | 450 | 450 | 450 | 450 | 3620 | |
| Alter | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 100 | 341 |
| Alter Rectified | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 100 | 220 |
| Total OK | 170 | 440 | 440 | 440 | 440 | 440 | 440 | 440 | 440 | 440 | 3520 | |
| WAST | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | 30 | |
| Frontpart | BR-3 | BR-3 | BR-3 | BR-3 | BR-3 | BR-3 | BR-3 | BR-3 | BR-3 | BR-3 | 30 | |
| Sidestam | BR-2 | BR-2 | BR-2 | BR-2 | BR-2 | BR-2 | BR-2 | BR-2 | BR-2 | BR-2 | 20 | |
| Instam | BR-6 | BR-6 | BR-6 | BR-6 | BR-6 | BR-6 | BR-6 | BR-6 | BR-6 | BR-6 | 60 | |
| Backpart | BR-6 | BR-6 | BR-6 | BR-6 | BR-6 | BR-6 | BR-6 | BR-6 | BR-6 | BR-6 | 60 | |
| Bottom | BR-4 | BR-4 | BR-4 | BR-4 | BR-4 | BR-4 | BR-4 | BR-4 | BR-4 | BR-4 | 40 | |
| Finishing Incharge | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | 30 | |
| Controller | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | SK-3 | 30 | |

SK=60
 B=174
 BR=24
 D=20

Floor Chief

P.M

Q.M